

Wednesday, 3/7/2007 4:26:17 PM

Kitt Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD ASSEMBLY LH/ DSI 9335
 Job Number : 31078
 Estimate Number : 12775
 P.O. Number : N/A Part Number : D350600241
 This Issue : 3/7/2007 S.O. No. : N/A Drawing Number : D3188, ICA, 11N CE 07.03.22
 Prsht Rev. : NC Project Number : N/A
 First Issue : 3/7/2007 Type : SMALL /MED FAB Drawing Revision : C
 Previous Run : N/A Material : N/A
 Written By : Due Date : 3/30/2007 Qty: 1 Um: Each
 Checked & Approved By : 07.03.08
 Comment : Est Rev: A 07.03.07 new issue ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG002

07/03/16

2.0 31078A SWITCH RELOCATION KIT



Comment: Sub-Component SWITCH RELOCATION KIT

B308 31080A
07/03/16

PTO

3.0 31078B SPACEPOD BODY LH

SEE SHEET
ATTACHED

Comment: Sub-Component SPACEPOD BODY LH

D3188-1M Batch: B30028(D3188-1M)ml 07/03/16

4.0 31078C SPACEPOD DOOR LH

D3186-1M / D3186-3
(30018) / B31078C

Comment: Sub-Component SPACEPOD DOOR LH

ml 08/03/16

5.0 D31871 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3187-1	Floor	<u>B25404</u>
1	D3186-3	Door (ref)	<u>N/A</u>
1	D3188-1	Body(ref)	<u>N/A</u>

ml 07/03/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Job Number: 31078

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

ALS41032130



ALS7-1030-130
per DSI 017



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)
insert
batch: M103495

ml 07/03/16

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Transfer drill (#30) from D3187-1 into D3188-1.
- 2-Open holes in D3188-1 body floor to Ø0.297".
- 3-Install inserts in D3188-1 as per Dwg D3188.
- 4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187
- 5-Deburr holes in D3187-1

ml 07/03/16

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 07/03/16 ①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*****D3187-1 floor only*****
Chemical Conversion Coat as per QSI 005 4.1

ML 07-03-16 ①

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*****D3187-1 floor only*****
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

ML 07/03/20

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/03/20

W/O:		WORK ORDER CHANGES					
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Job Number: 31078

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
batch: M24628

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

M102565

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Label
batch: B27863 X1

17.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B30169 X1

18.0

D35471

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET
batch: B30636 X1

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Job Number: 31078

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35501

STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: B31148 X1

20.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210 X1

21.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: M31127 X1

22.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B30680 X2

23.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: M3022 X4 M102455

24.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: B31123 X2

25.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B21490 X2

A 3235-020-935

Washer x8: M100477

Need these
washers

W/O:		WORK ORDER CHANGES					
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Job Number: 31078

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M103574 x4

27.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M102842 x4

28.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M103538 x4

29.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-1 floor with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for body & floor*

M107/03/28

30.0

D35527

CARBON STEEL GAS SPRING

WA



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B30638 x1

31.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585 x2

32.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M102842 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 31078

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100993 X2

34.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M103538 X2

35.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: B30681

36.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: M31127 X1

37.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: B29021 X2

38.0

D2585

Latch Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: B28019 X2

39.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: B25903 X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 31078

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M18057 X 2 -

41.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: ~~M10364~~ M103585 X 2

42.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M102658 X 2

43.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B26501 X 1

44.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B26408 X 1

45.0

D2228

Backing Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: B31237 X 4

46.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M103585 X 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31078

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
batch: M 102842 x12

48.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut
batch: M 103538 x12

49.0

D35571

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BRACKET
batch: B30644 x1

50.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD
batch: ~~B02~~ B30210 x1

51.0

AN960JD516

Washer



Comment: Qty.: ~~1.0000~~ Each(s)/Unit Total : 1.0000 Each(s) Qty 2
Washer
batch: M 102519 x2

Need 2 Washers

52.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B 30169 x1

53.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: M 9216 x2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31078

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch:

M103585

X 2

55.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ~~107~~ D350-600

Hardware on previous steps is for door ass'y*

11N

REV C.

07.03.22

56.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2070405

57.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M103480

a.m

07/03/16

(1)

58.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

M107/03/20

59.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

D31130

07/04/05

60.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/04/05

(1)

61.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev:

A

07/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/04/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31078

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

62.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
R 07104105

Job Completion



U 07-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

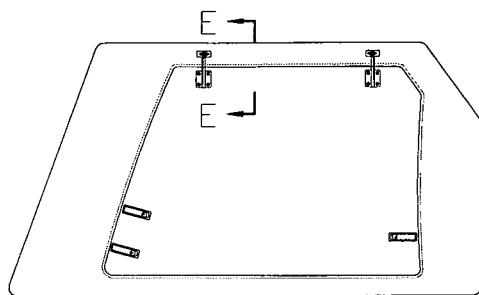


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

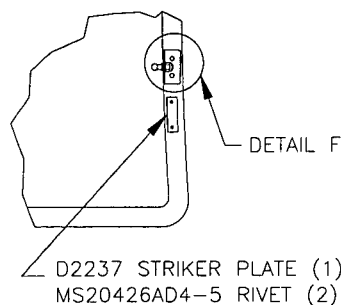


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

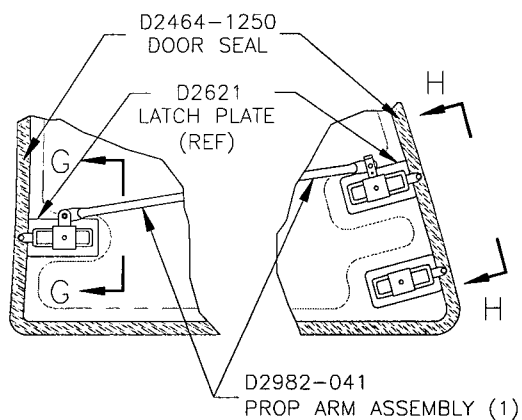
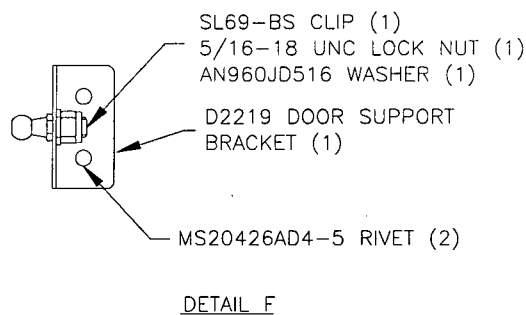


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



TC Accepted

MAY 07 2003

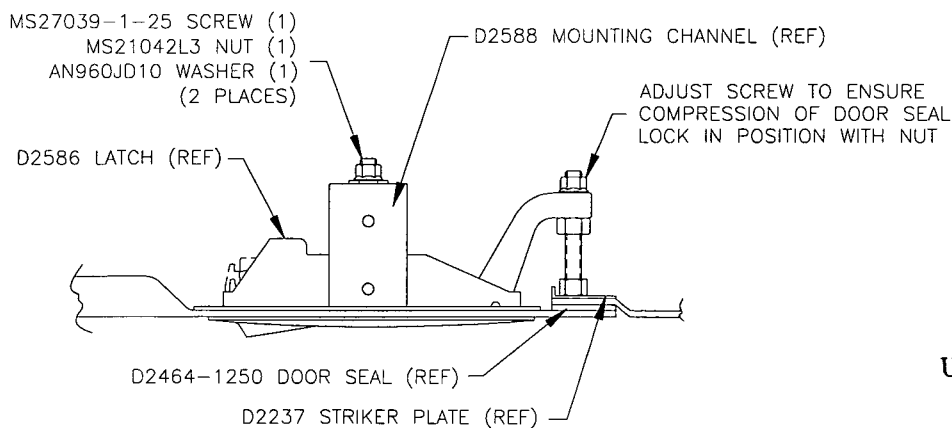
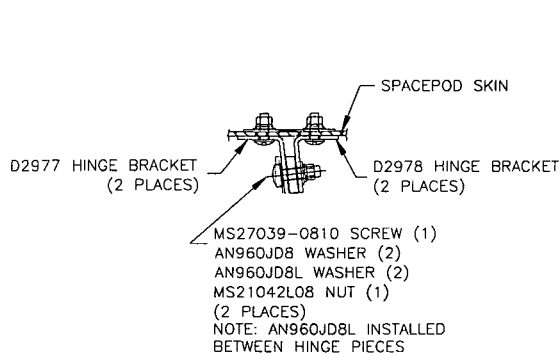


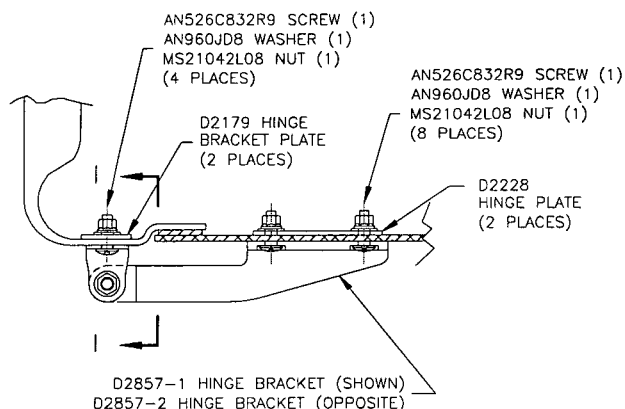
FIGURE 6. TYPICAL LATCH INSTALLATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31078

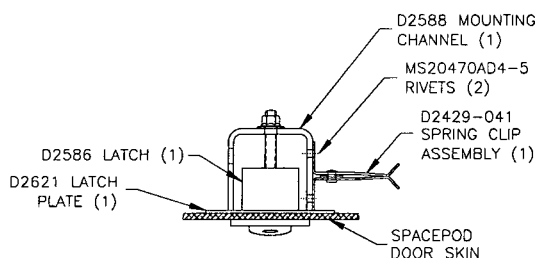
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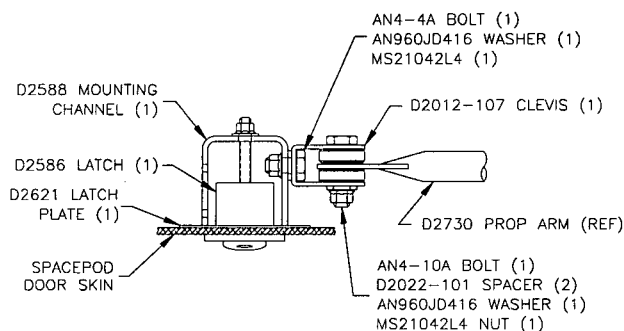
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



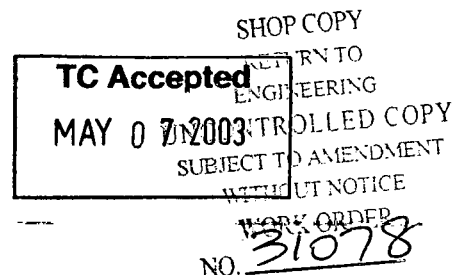
SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.



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DART

HAWKESBURY, ONTARIO, CANADA

DART AEROSPACE LTD

DESIGN	DRAWN BY	DART AEROSPACE LTD	
JB	CE		
CHECKED	APPROVED	DRAWING NO.	REV. D
JB	CE	D3188	SHEET 1 OF 11
DATE	TITLE	SCALE	
07.02.22	SPACEPOD BODY	NTS	
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

RELEASED

07.02.22

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SHEDULE:

PART
D3188-1M/-1/-5
D3188-2M/-2/-6
D3188-3M/-3/-7

LAYUP
DT8003
DT8004
DT8500

TRIM AND DRILL
DT8501
DT8502
DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

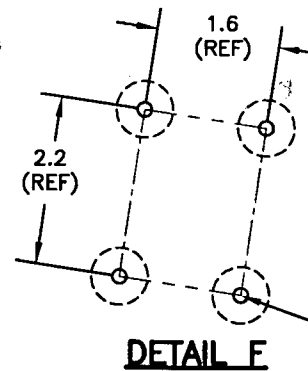
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 31078

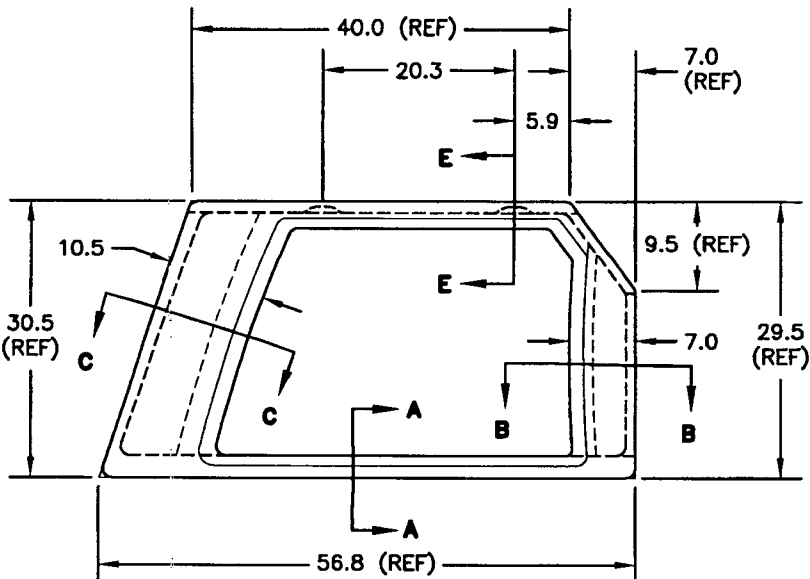
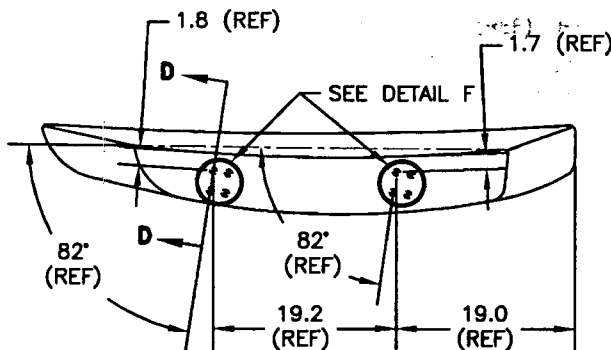
DART

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07.02.27

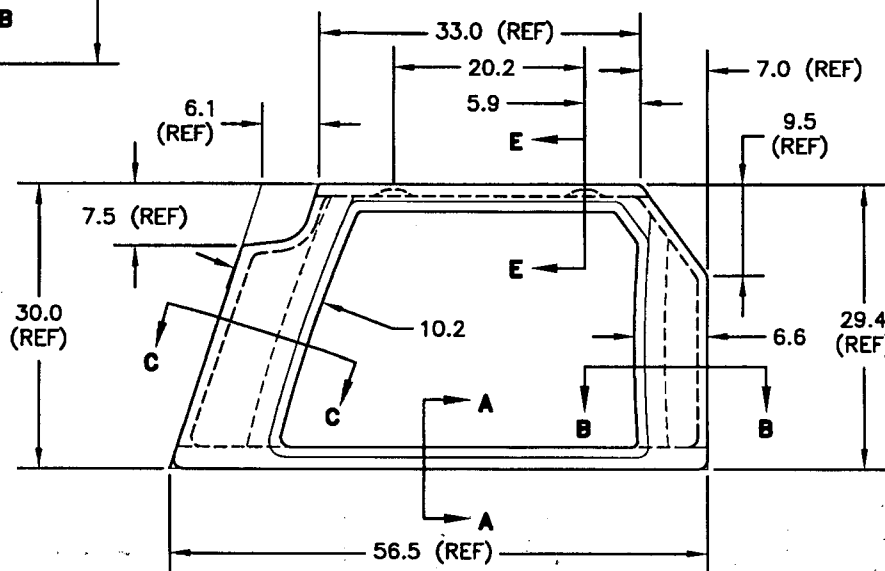
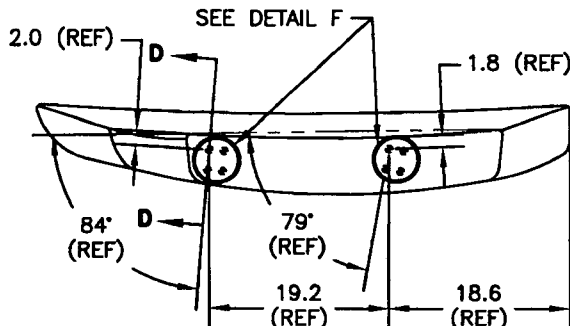
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CHECKED		APPROVED		
DATE	07.02.22	TITLE	SPACEPOD BODY	
		DRAWING NO.	D3188	REV. D
				SHEET 2 OF 11
				SCALE
				NTS



INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

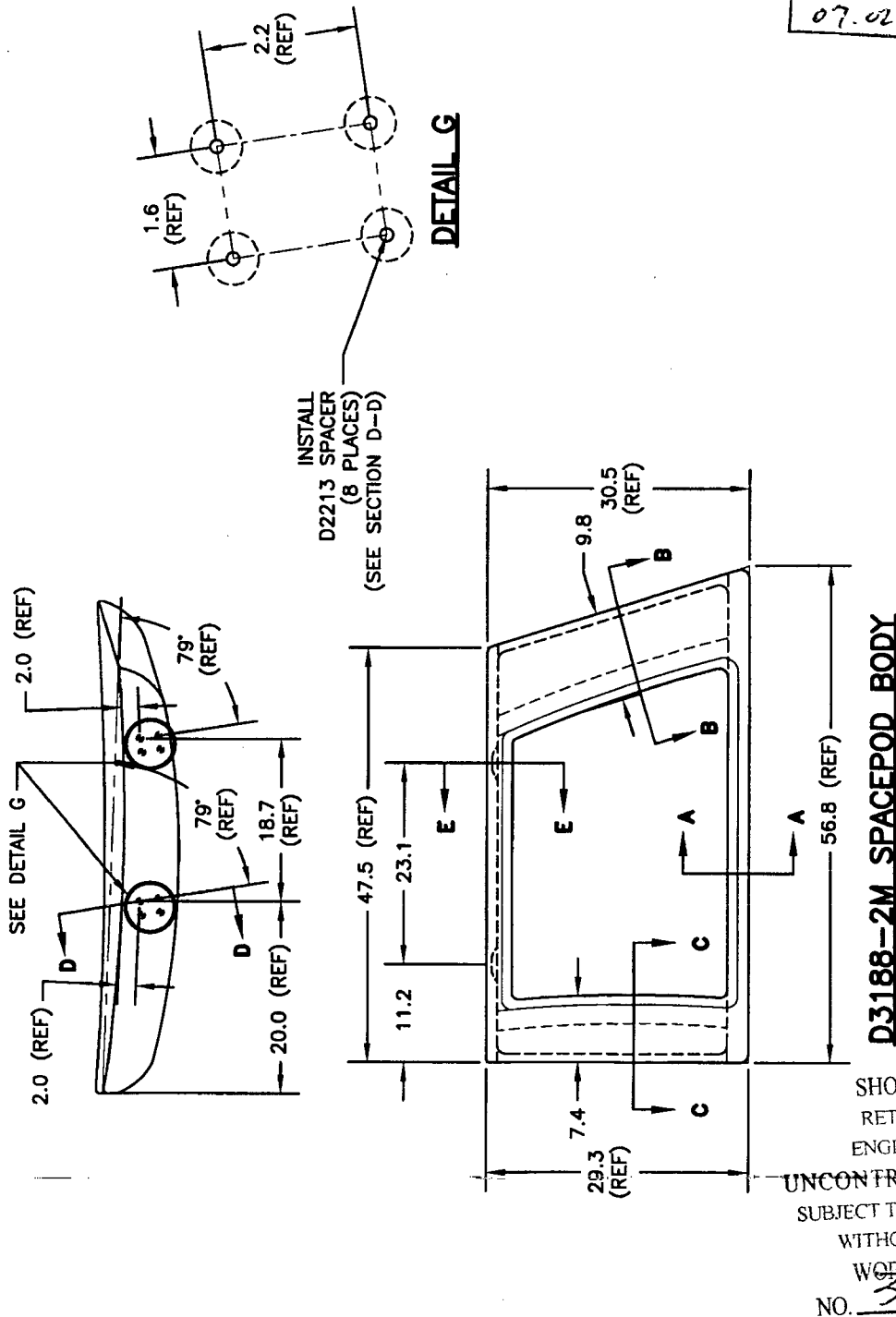
D3186-1M/-3M NOTES:

1. REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2. SEE SHEET #4 FOR SECTION VIEWS.

SHOP COPY
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NO. 31078

DART

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. D SHEET 3 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED07.02.27 *[Signature]*

D3186-2M NOTES:
1. REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2. SEE SHEET #4 FOR SECTION VIEWS.

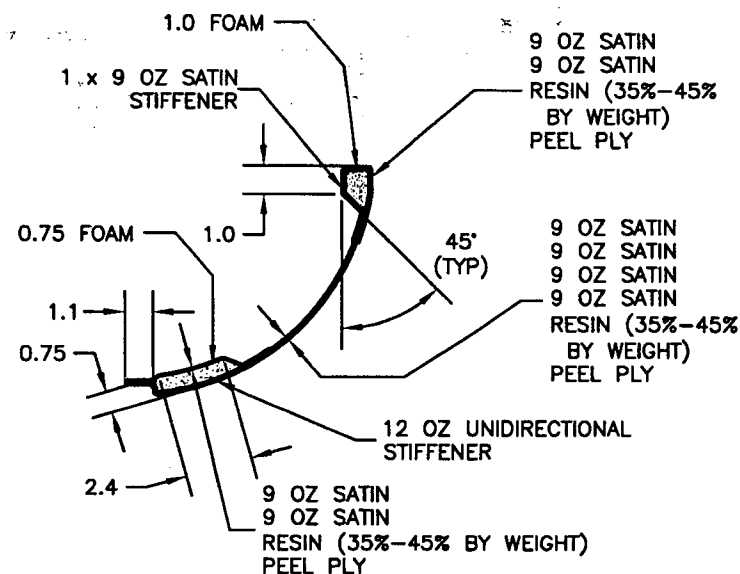
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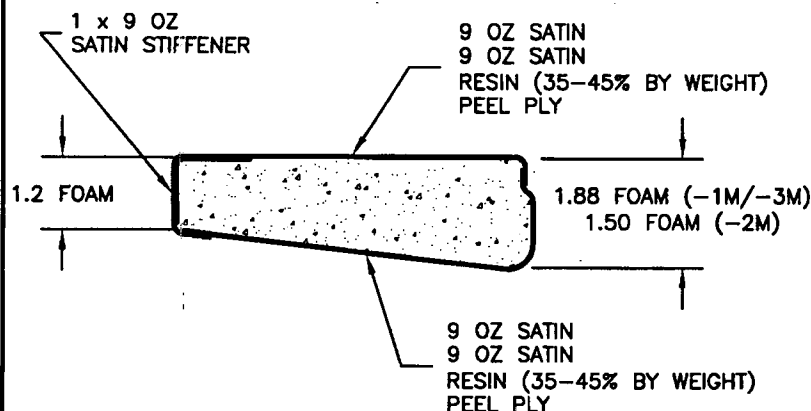
DART

DESIGN	JB	DRAWN BY	CE	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.02.22	TITLE	D3188	REV. D
			SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

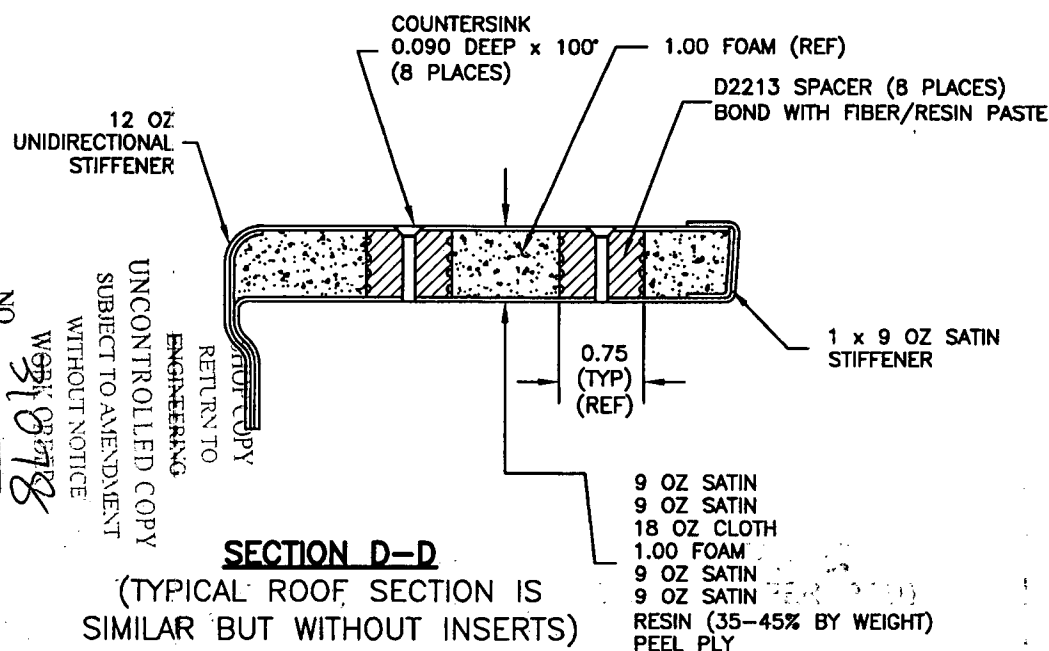
RELEASED
07.02.27



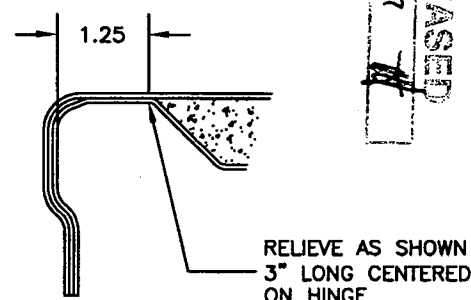
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



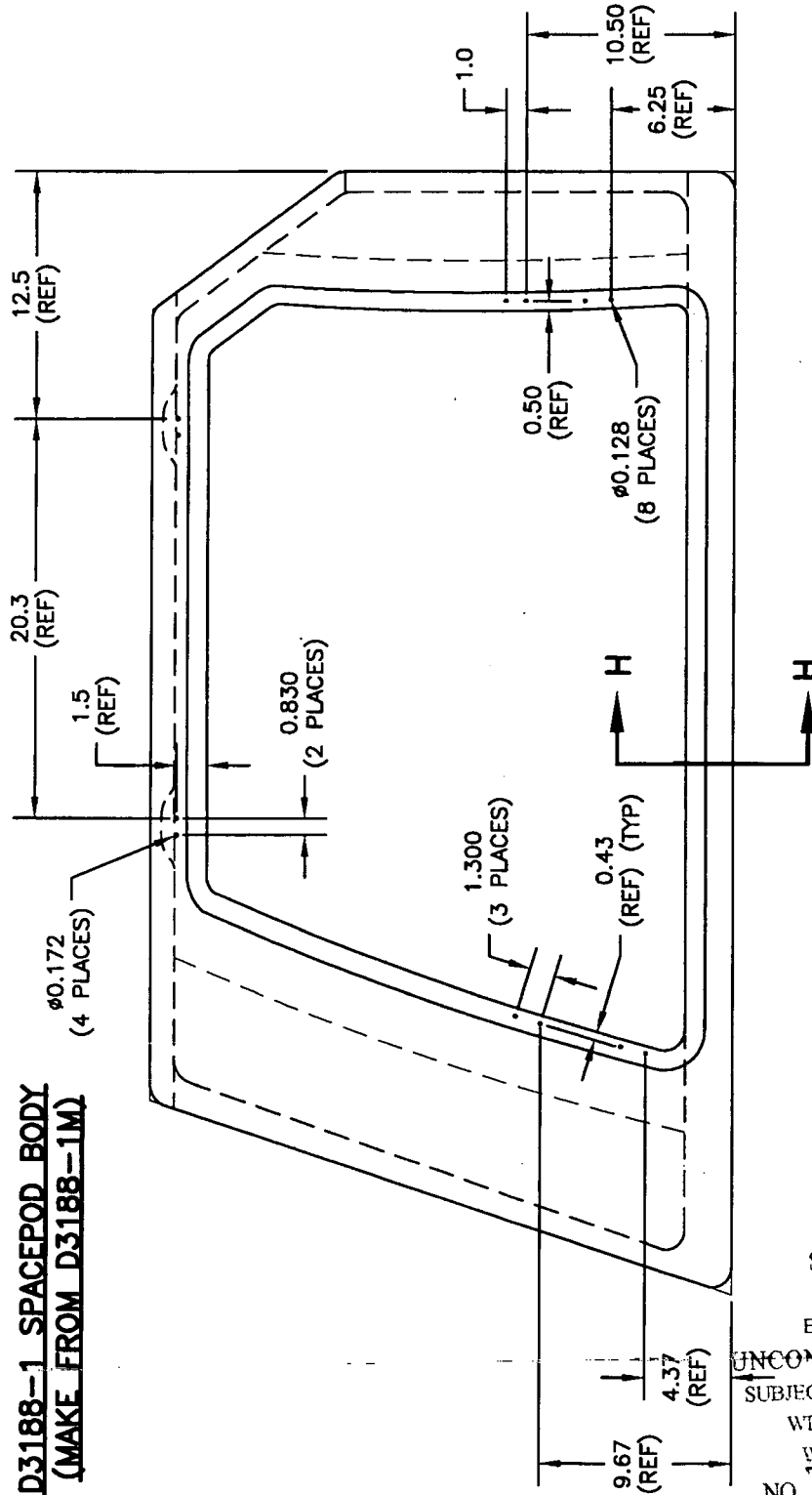
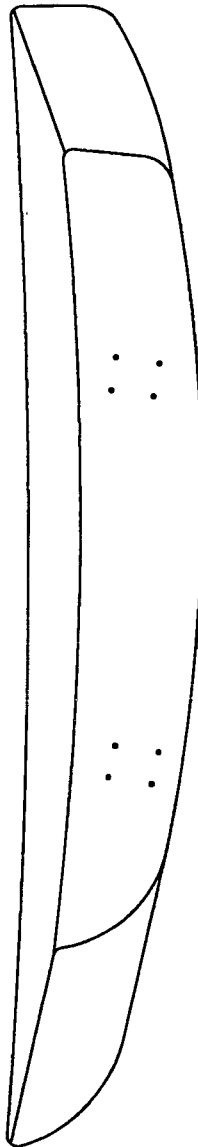
SECTION E-E
(2 PLACES PER POD)

DART

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 5 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07-02-22



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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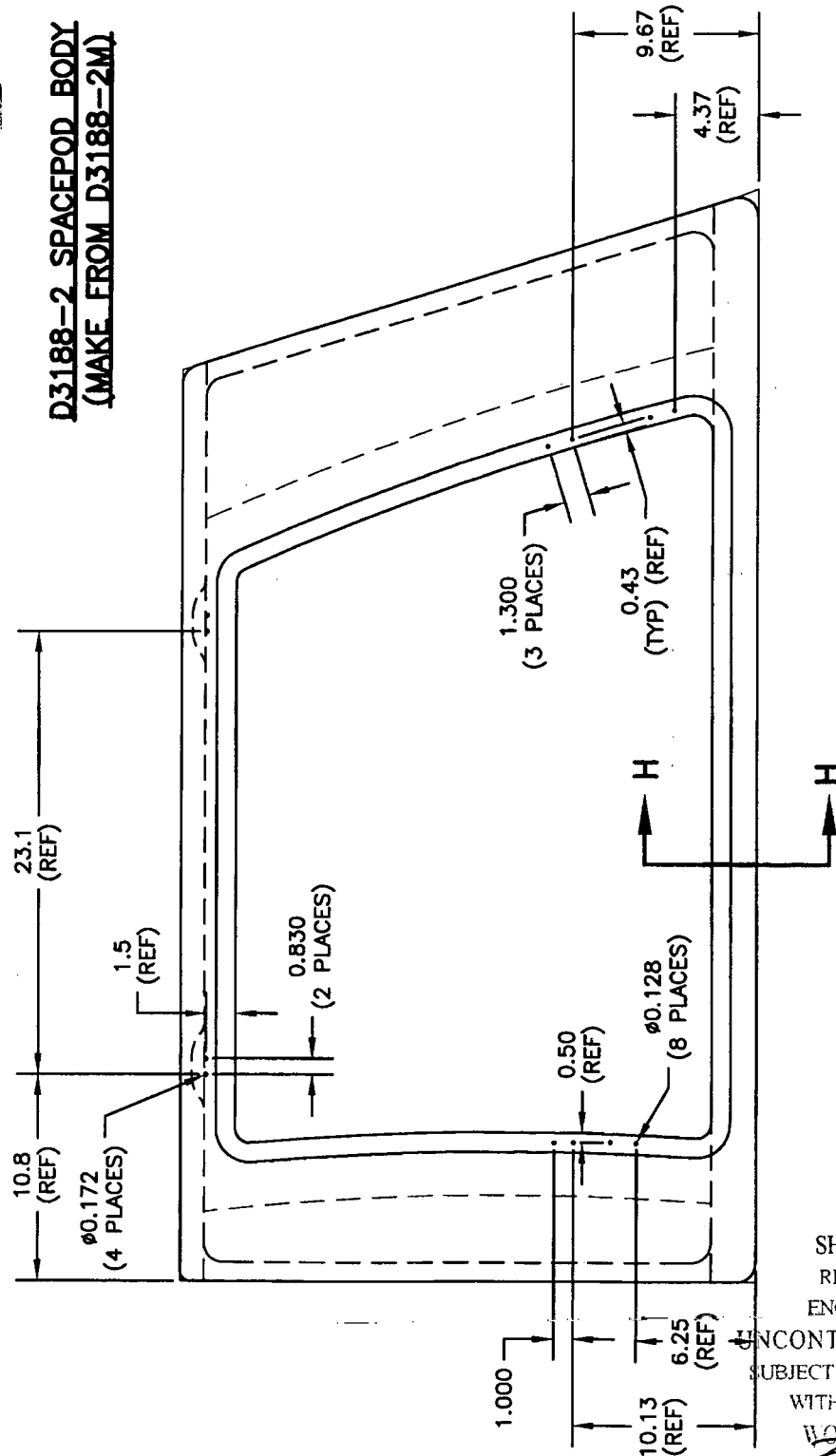
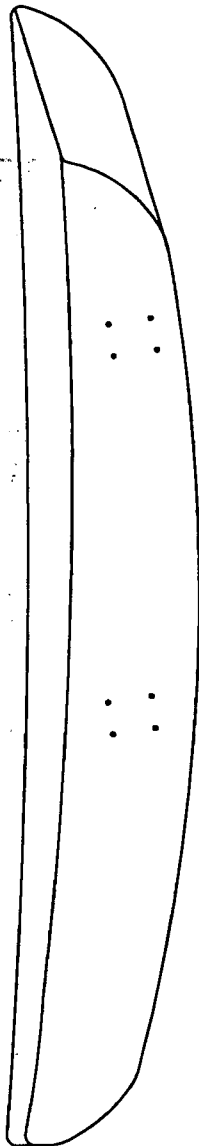
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CHECKED JB	APPROVED LE	DRAWING NO. D3188	REV. D SHEET 6 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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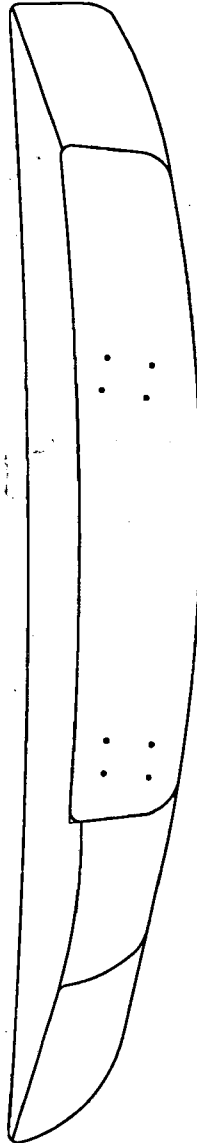
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DART

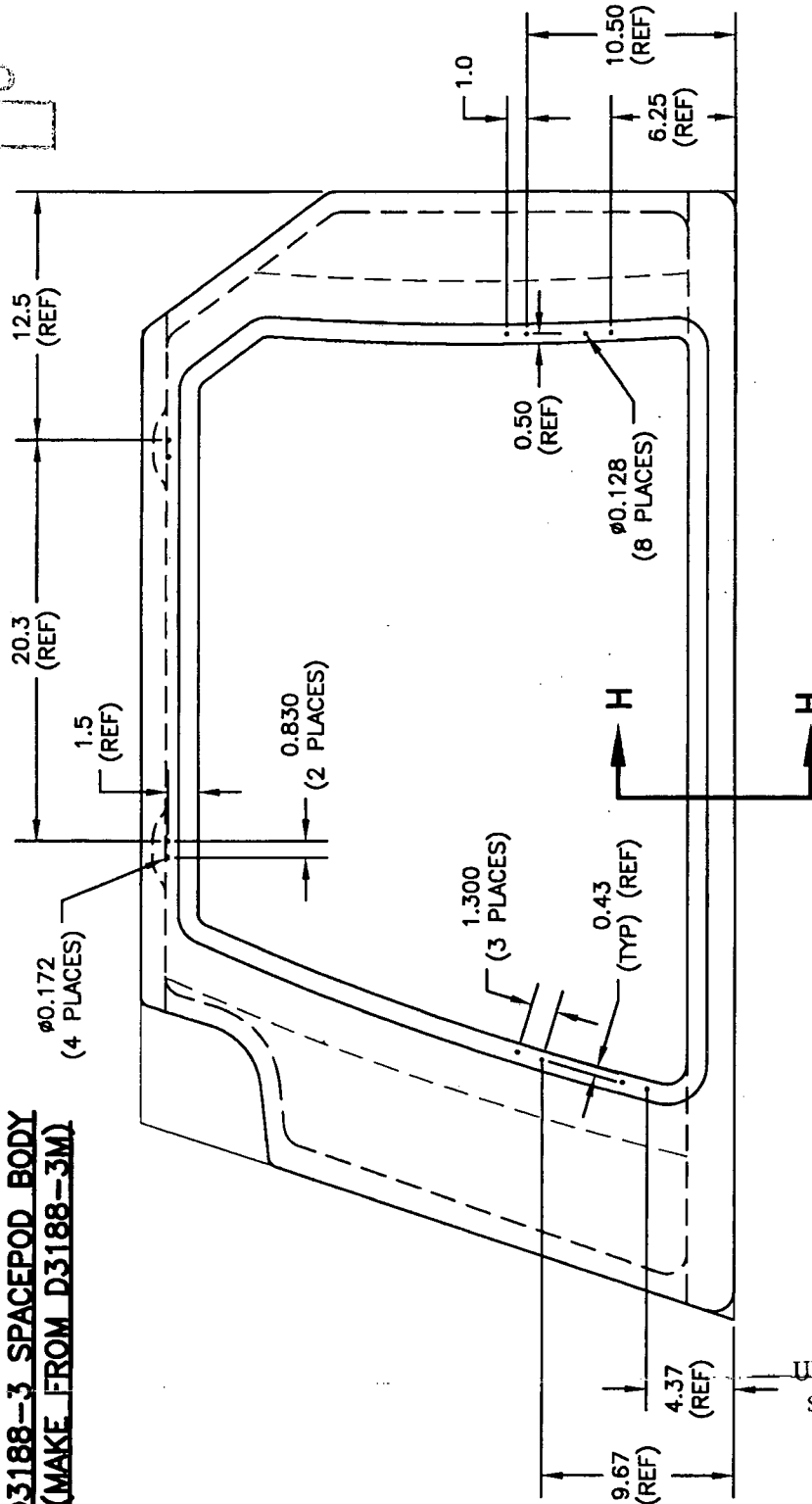
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 7 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27



**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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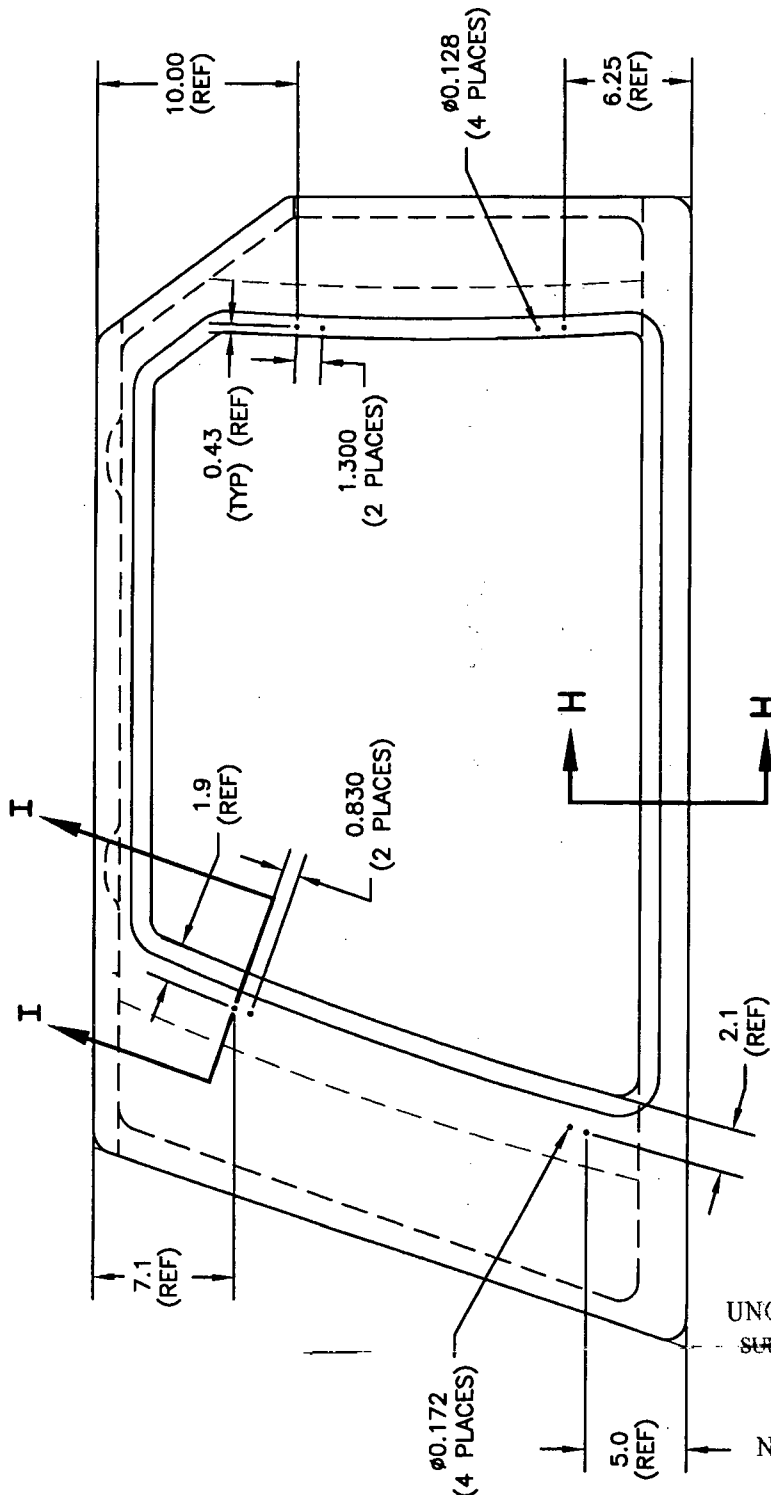
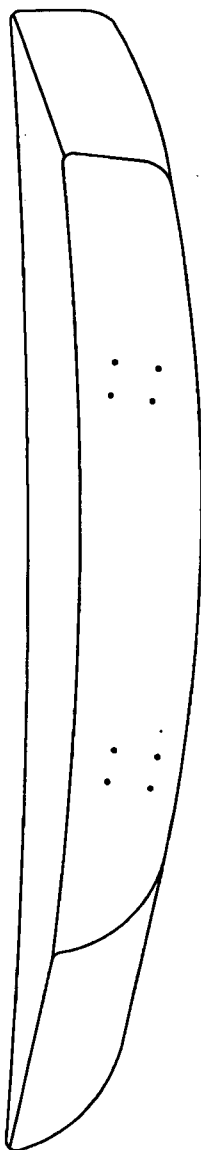


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CHECKED JB	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 8 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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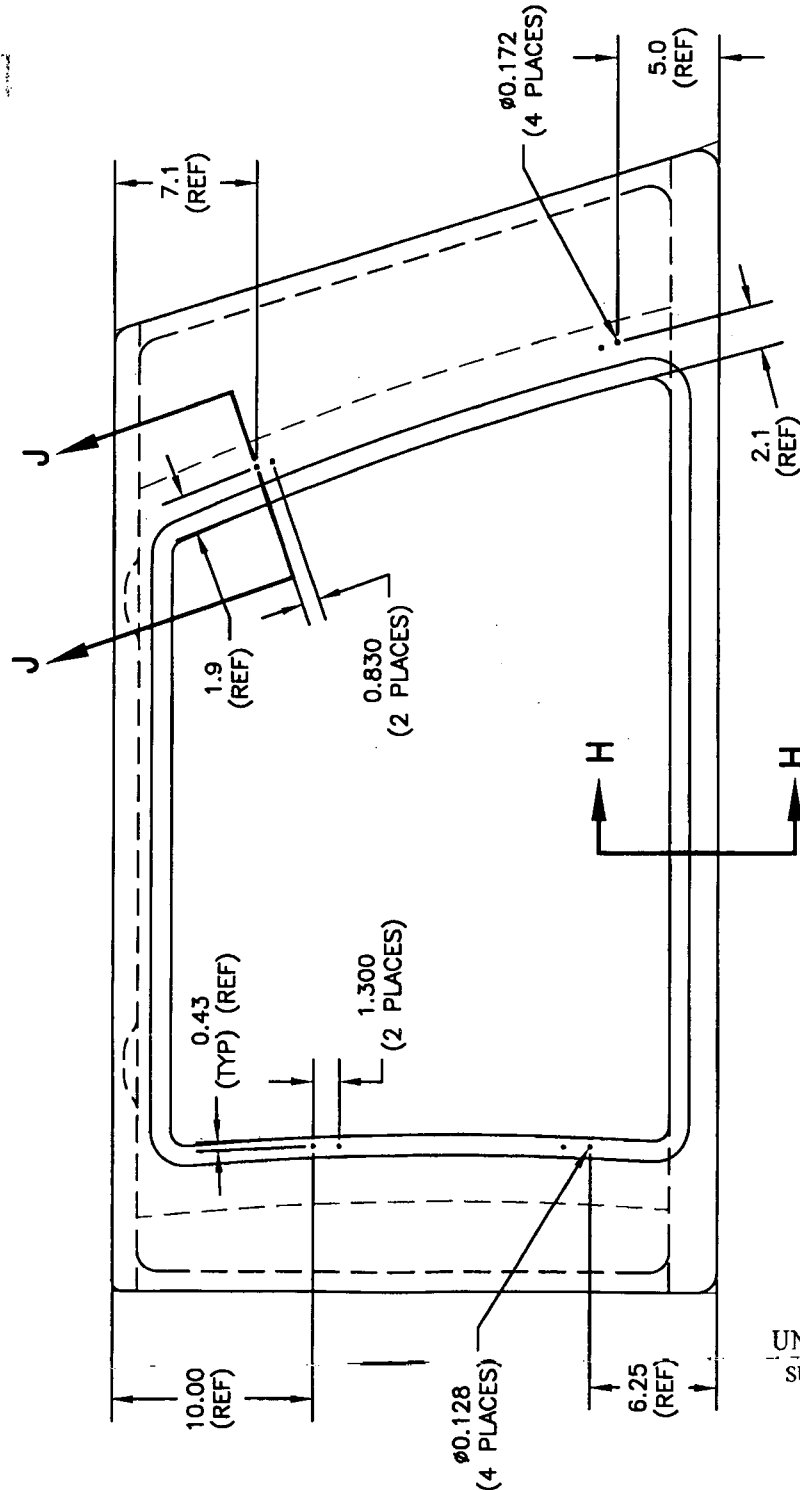
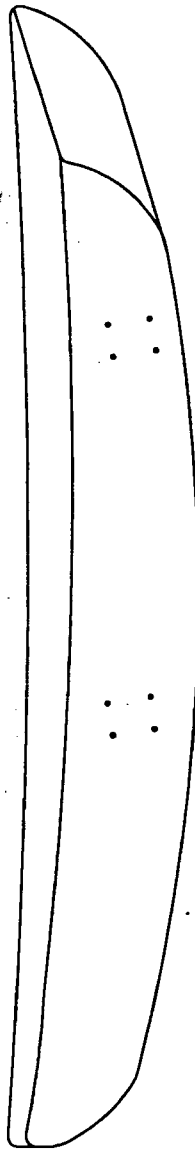
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DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3188	REV. D SHEET 9 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.02.27

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS
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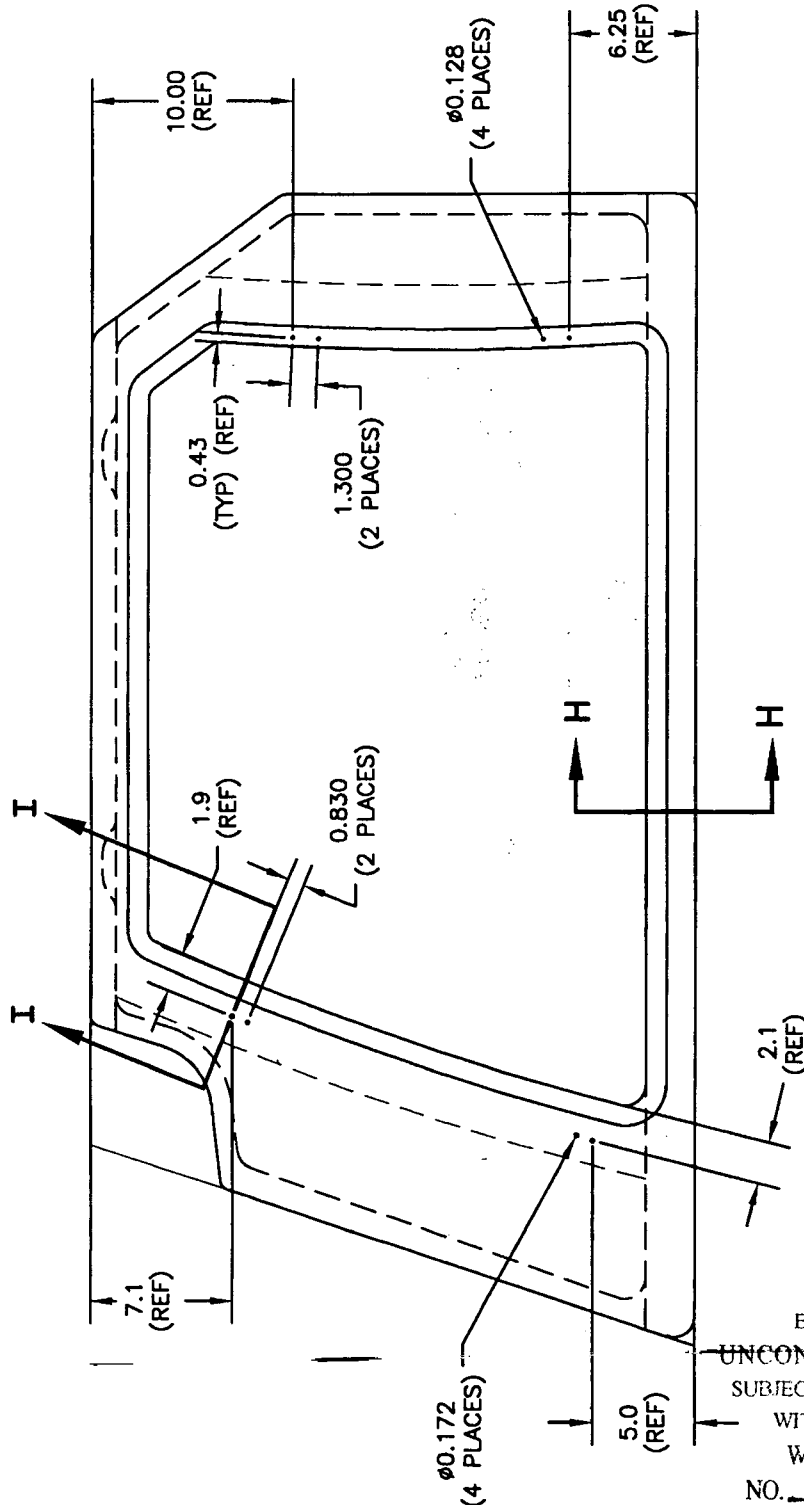
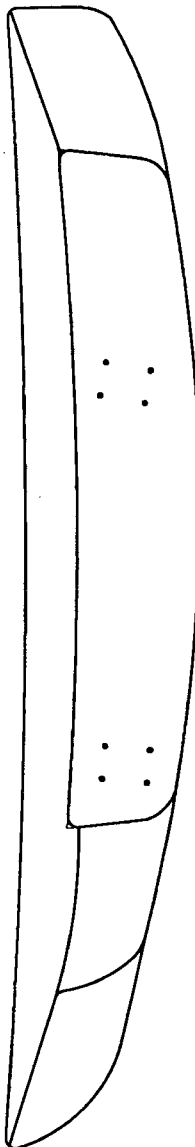
DART

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, - ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3188	REV. D SHEET 10 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07-02-22

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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CHECKED B	APPROVED [Signature]	DRAWING NO. D3188	REV. D SHEET 11 OF 11
DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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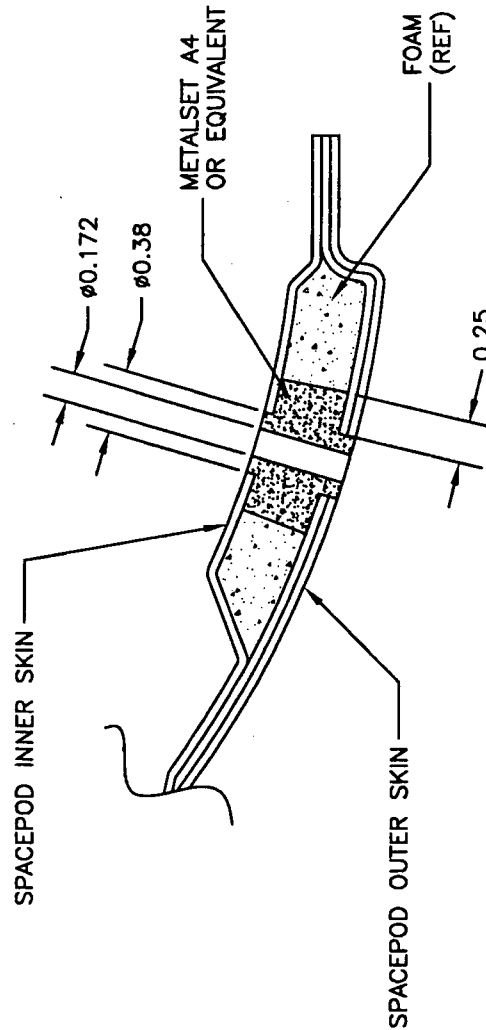
07.02.27

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Thursday, 12/10/2006 11:10:57 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : INITIAL PROTOTYPE TEMPLATE
 Job Number : 00065A
 Estimate Number : 10068
 P.O. Number :
 This Issue : 12/10/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : 12/07/2006 Type : R&D MACHINED PARTS
 Previous Run : 00064A
 Part Number : INITIAL PROTOTYPE
 Drawing Number :
 Project Number : N/A
 Drawing Revision :
 Material :
 Due Date : 28/06/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Project #: Description:

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

-Fill 375 holes with hysol 934NA A/B B

M101268

Add milled fibre B

B M101268

Repair holes IAW IIN D350-600 para 3.4.9

Re do for Spacepod 4/H
 w/o 31078

Hypol 934 ~~M101268~~ M103922
 milled fiber M100859 10% by weight

PT002

→ Made Holes bad position. fill them with
 Hypol M103922 and
 milled fiber 100859

ml 07/03/21

ml 07/03/29

Leanne Elsliger

From: David Shepherd [dshepherd@dartaero.com]
Sent: March 21, 2007 3:55 PM
To: 'Leanne Elsliger'
Cc: 'S Shahbazian'
Subject: RE: Metalset A4

It is acceptable to substitute the Hysol 934NA for the Metalset A4 on the -241/-242 Spacepods. Please update D3188 to make this a permanent change.

David

From: Leanne Elsliger [mailto:lelsiger@dartaero.com]
Sent: Wednesday, March 21, 2007 11:54 AM
To: 'David Shepherd'
Cc: 'S Shahbazian'
Subject: Metalset A4

Hi David –

Per work orders 31078 and 31083, the -241/-242 Spacepod kits are being assembled. To install the D3538-1 hinge brackets, 3/8" holes are drilled and filled with Metalset A4 or equivalent per D3188 rev D. For the test, we used Hysol 934NA mixed with milled glass fibers as the 'equivalent'. In the IIN, we give the option of Metalset A4 or Hysol 934NA w/ milled glass fibers. For these w/o's please provide approval to use Hysol 934NA with milled glass fibers as the 'equivalent'.

Thanks,
Leanne

Leanne Elsliger, P.Eng
Design Engineer
Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury, ON, K6A 1K7
T: (613) 632-5200
F: (613) 632-9311

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.413 / Virus Database: 268.18.16/729 - Release Date: 3/21/2007

--
No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.413 / Virus Database: 268.18.16/729 - Release Date: 3/21/2007

22/03/2007

Date: Wednesday, 3/7/2007 4:20 PM
 User: Kim Johnston

Process Sheet

13

Customer: CU-DAR001 Dart Helicopters Services
 Job Number: 31078
 Estimate Number: 12775
 P.O. Number:
 This Issue: 3/7/2007 S.O. No.:
 Prsht Rev.: NC
 First Issue: 3/7/2007 Type: SMALL /MED FAB
 Previous Run:
 Written By:
 Checked & Approved By: 07.03.08
 Comment: Est Rev: A 07.03.07 new issue ec

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335
 Part Number: D350600241
 Drawing Number: D3188, ICA
 Project Number: N/A
 Drawing Revision: C
 Material:
 Due Date: 3/30/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600241 CHG002001

07.03.16

2.0

31078A

SWITCH RELOCATION KIT



Comment: Sub-Component SWITCH RELOCATION KIT

3.0

31078B

SPACEPOD BODY LH



Comment: Sub-Component SPACEPOD BODY LH

D3188-1M Batch: _____

4.0

31078C

SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH

5.0

D31871

Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-1 Floor _____

1 D3186-3 Door (ref) _____

1 D3188-1 Body(ref) _____

REFERENCE ONLY

Date: Wednesday, 3/7/2007 4:26:36 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 31078C		
Estimate Number	: 12635		
P.O. Number	:	Part Number	: D31863
This Issue	: 3/7/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	:	Material	:
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>HA 07.03.08</u>		
Comment	: Est Rev: A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	31078C01	SPACEPOD DOOR LH
-----	----------	------------------



Comment: Sub-Component SPACEPOD DOOR LH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

ml 07/03/19

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

ml 07/03/19 (1)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/03/19 x1

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

ml 07/04/05/ (1)

Job Completion



u 5/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



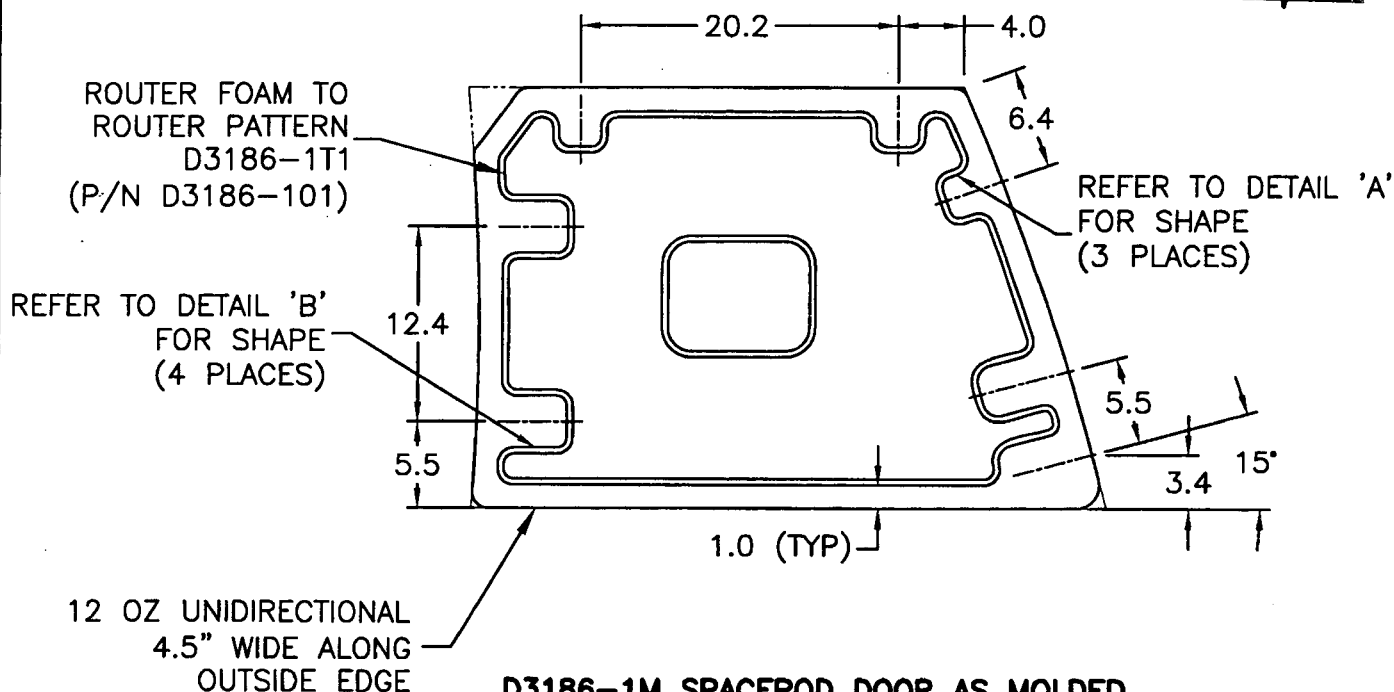
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H



D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

NO. 31078C

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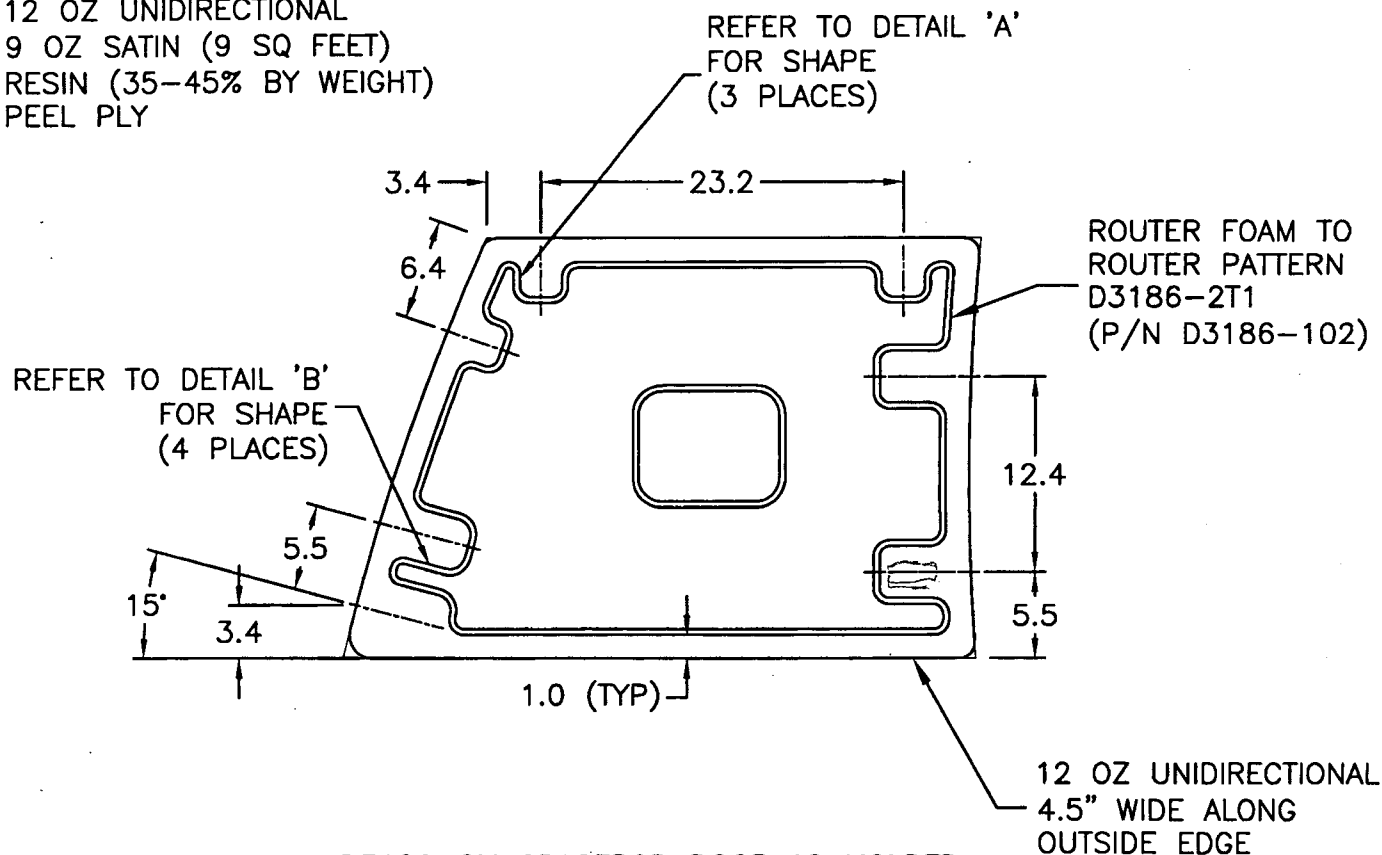
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144
- 8) ALL DIMENSIONS ARE IN INCHES
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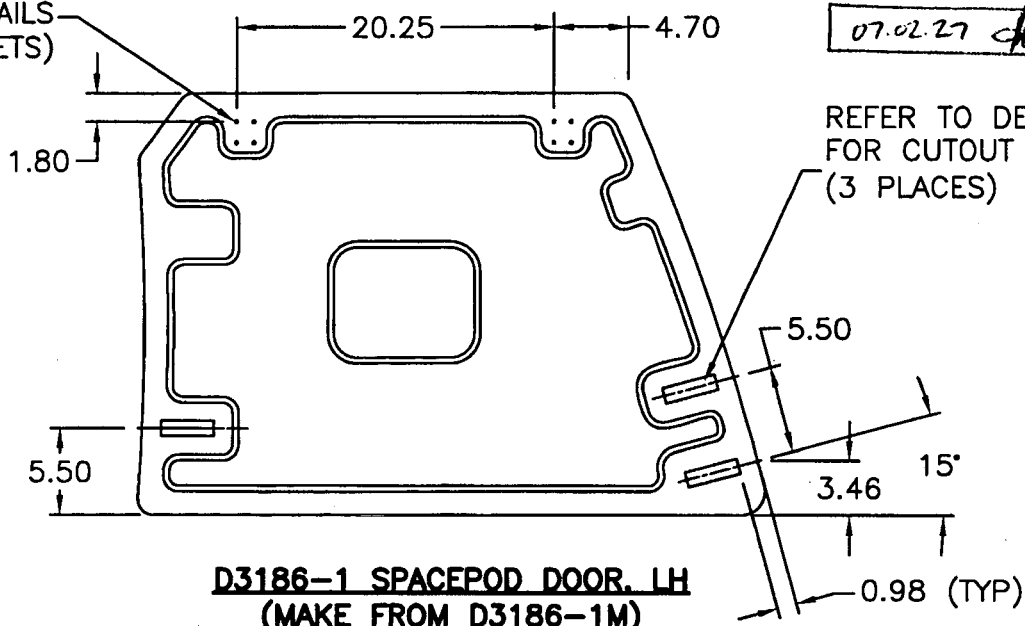
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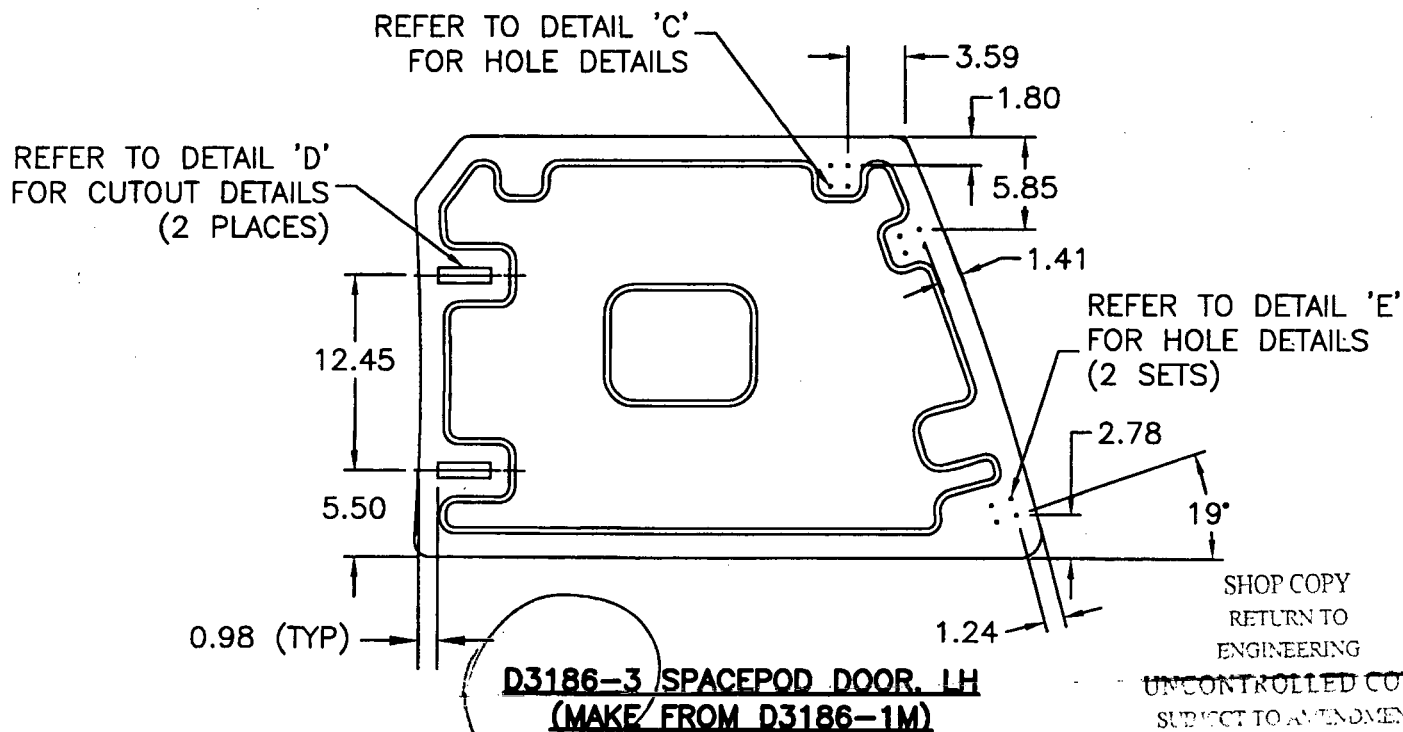


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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)



NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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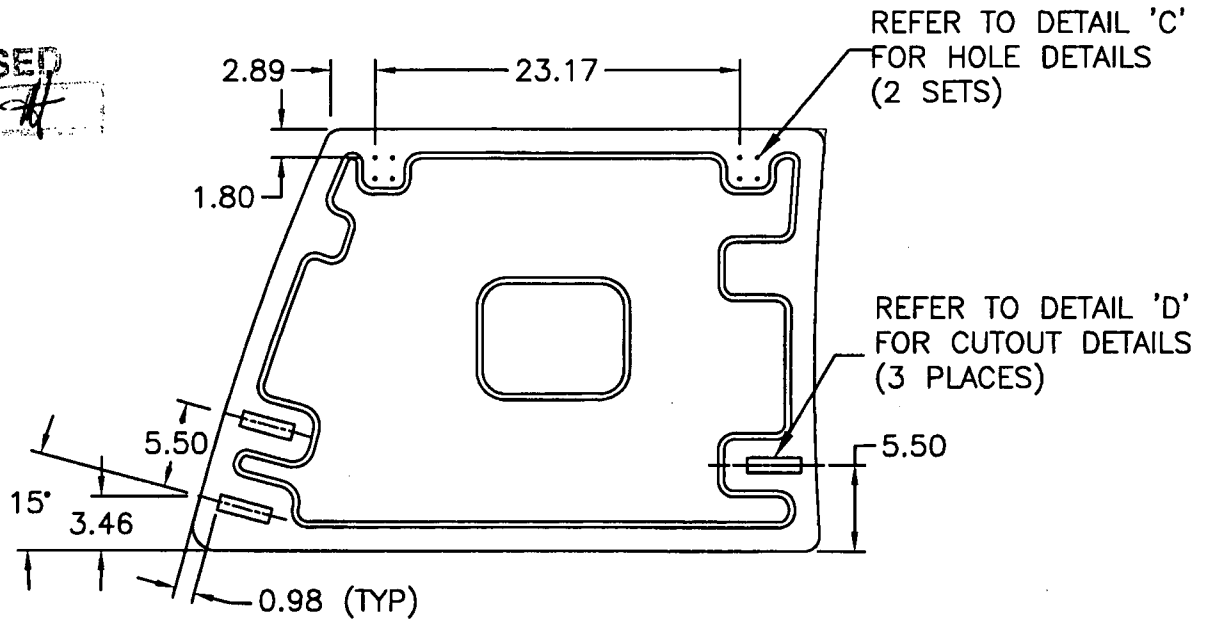
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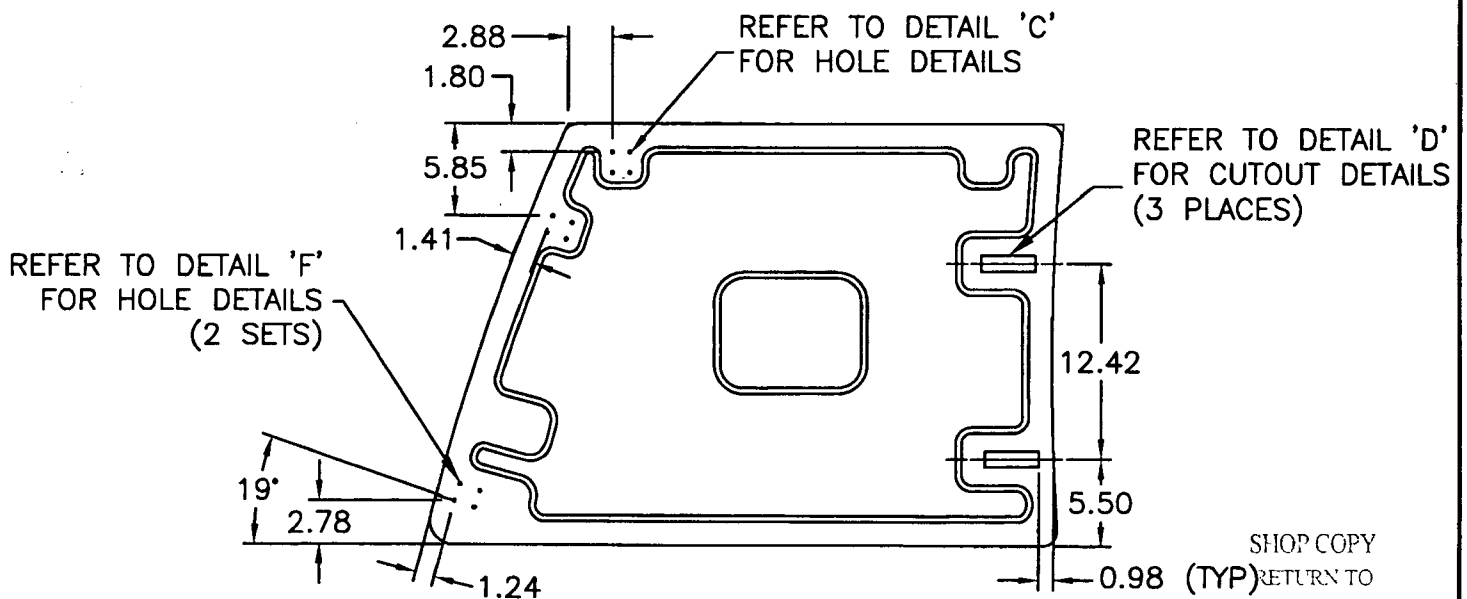
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
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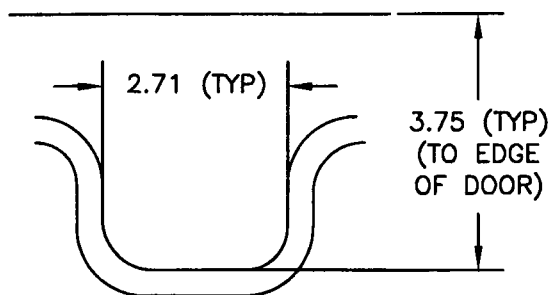
WORK ORDER
NO. 31078C

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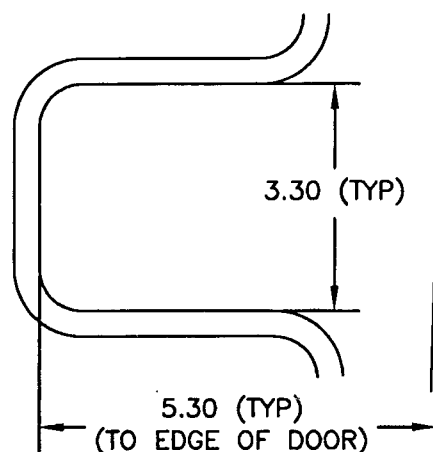
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



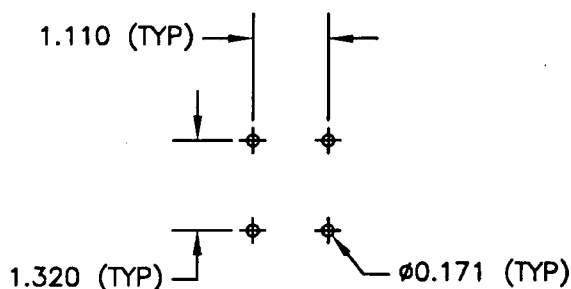
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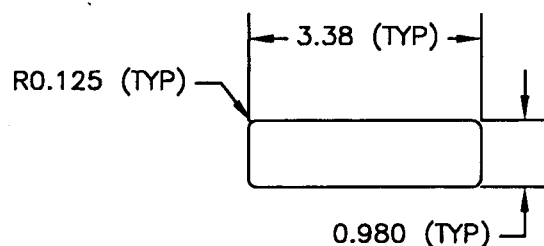
DETAIL B

RELEASED

07.02.27 [Signature]

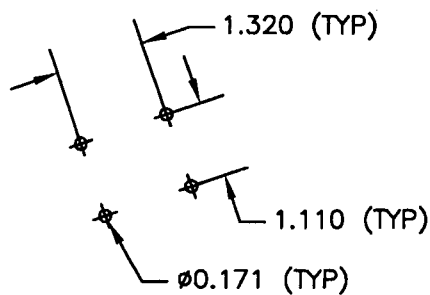


DETAIL C

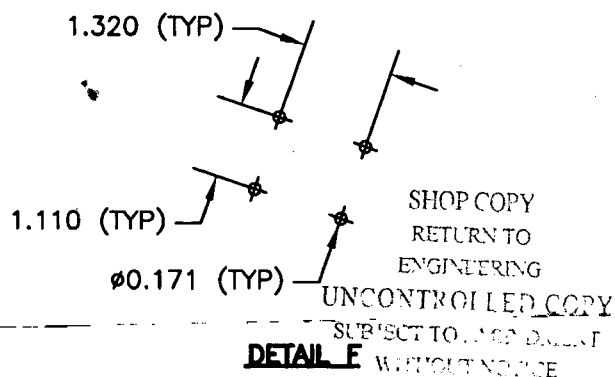


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 31078C

Wednesday, 12/20/2006 1:44:43 PM

User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 30018
Estimate Number : 12598
P.O. Number :
This Issue : 12/20/2006 **S.O. No.** :
Prsht Rev. : NC
First Issue : 11 **Type** : PURCHASED PARTS
Previous Run : 30017
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 06-12-04 ec

Drawing Name : SPACEPOD DOOR LH
Part Number : D31861M
Drawing Number : D3186 REV *EC LE 07-01-18*
Project Number : N/A
Drawing Revision : *EC LE 07-01-18*
Material :
Due Date : 2/10/2007 **Qty:** 1 **Um:** Each

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *2767*

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

C Lede 112121 @

2.0 D31861P Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Spacepod Door

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *M-4**Pc 7/3/06 C*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:44:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 30018

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8-24-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

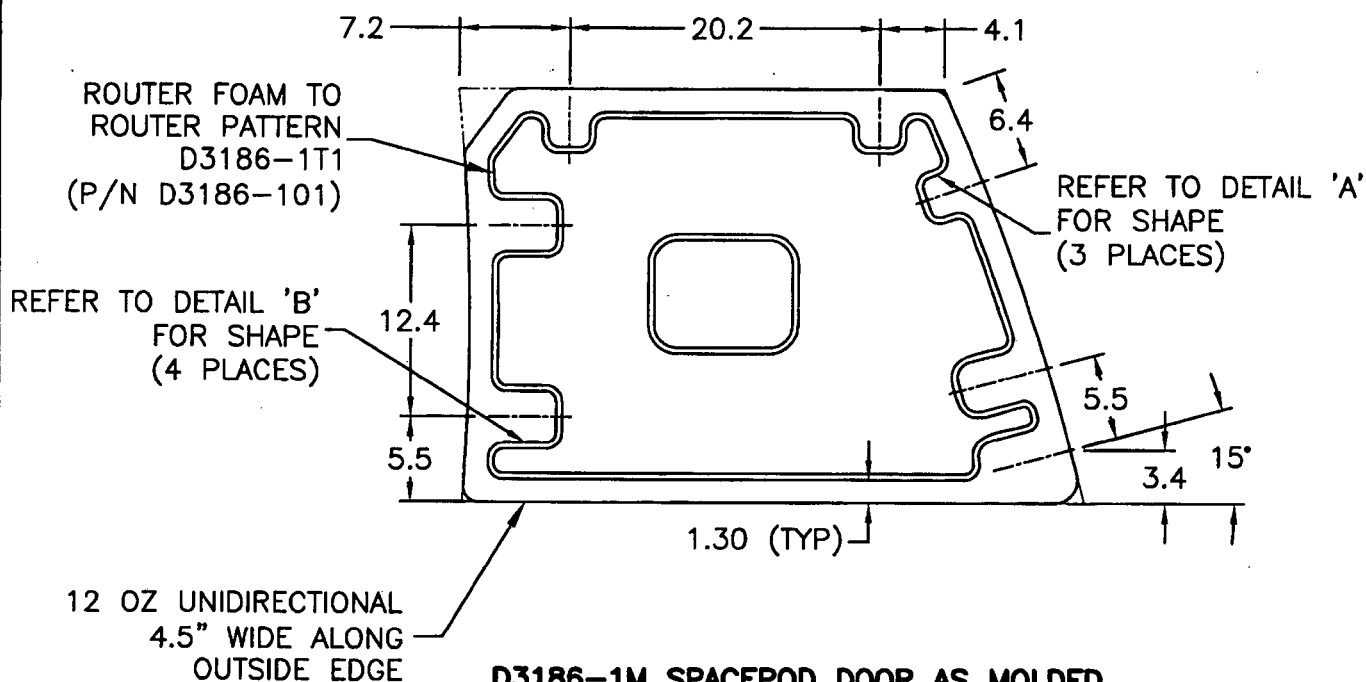
NOTE: Date & initial all entries



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CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

RELEASED
06.12.22

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION-SCHEDULE-PER-THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
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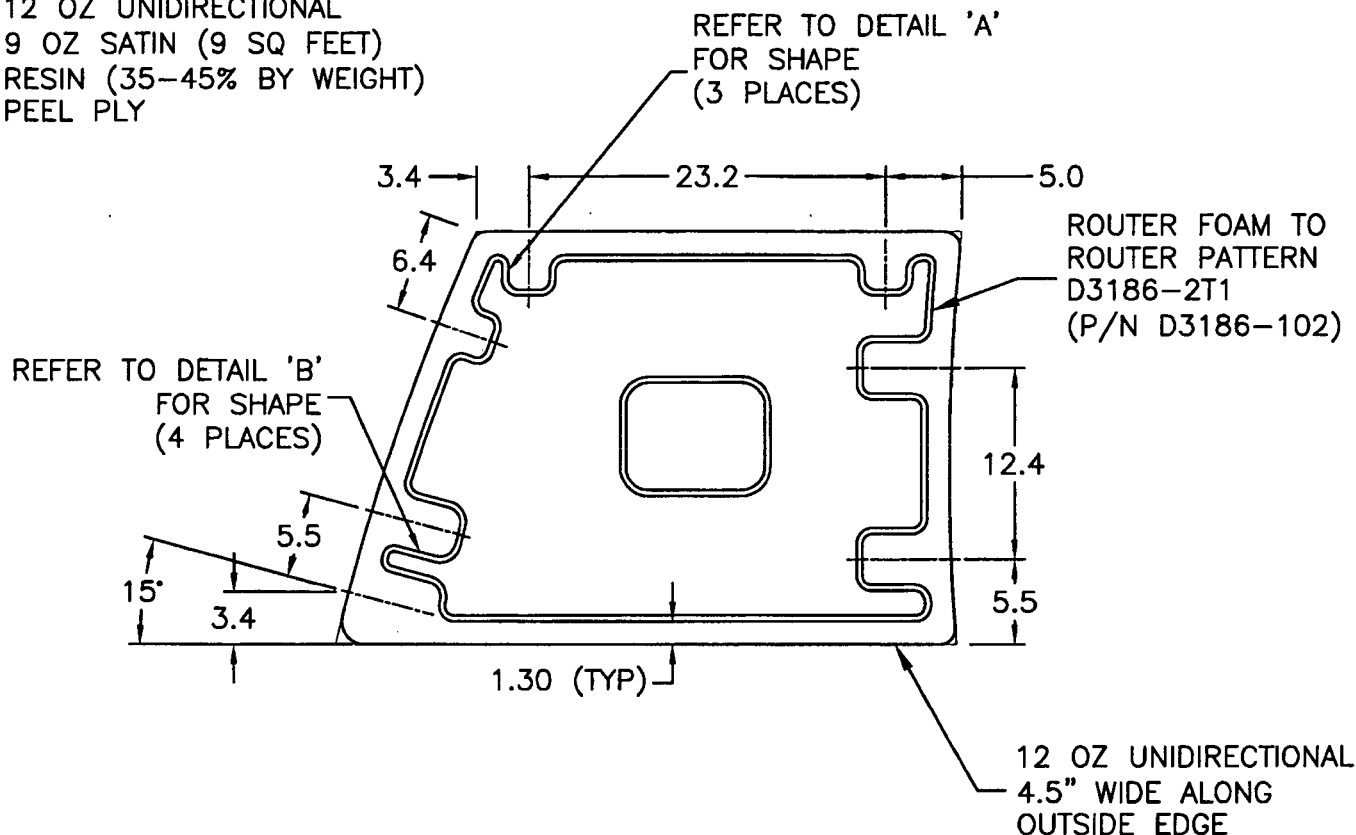
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CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
06.12.13

D3186-2M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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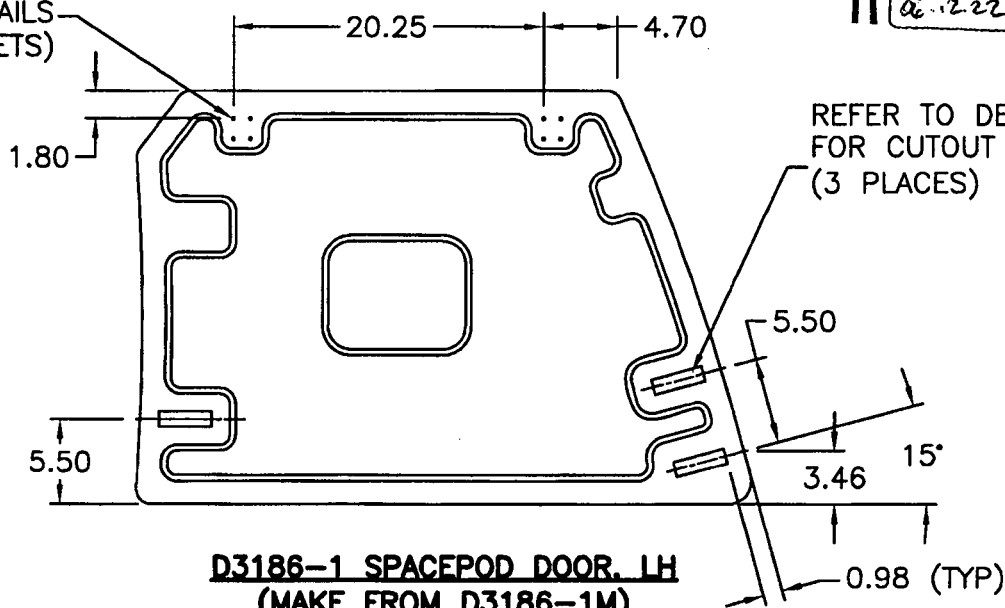
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

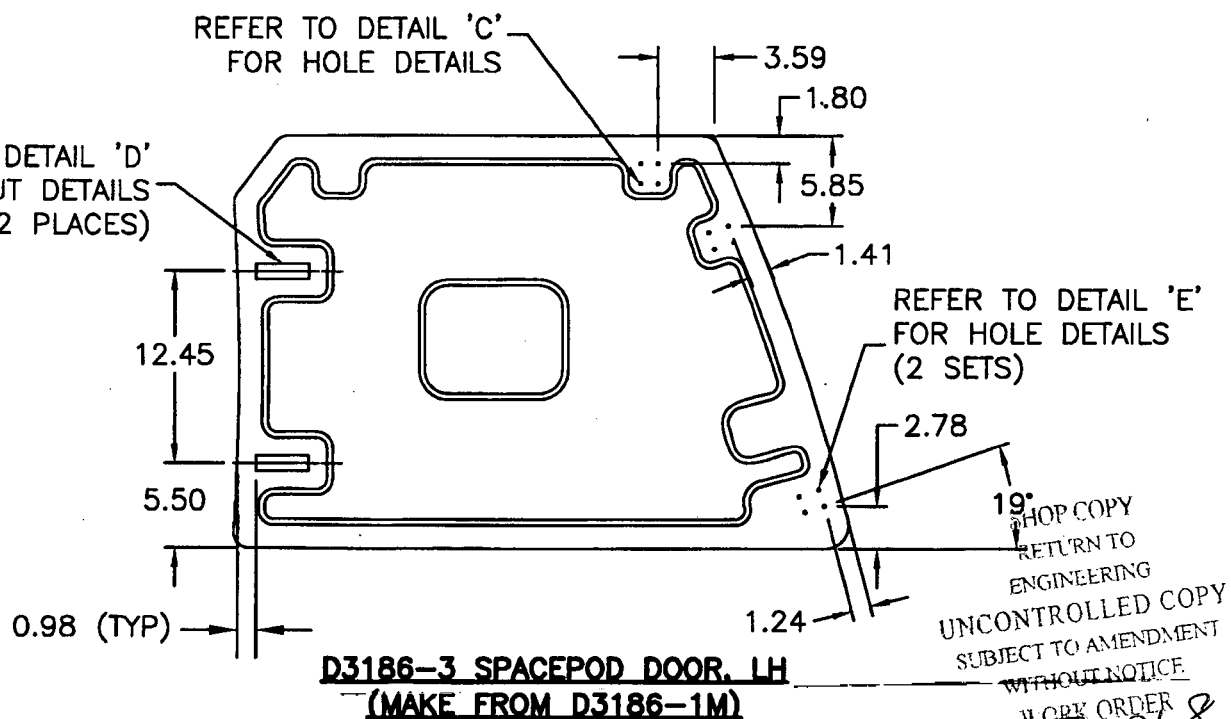
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06.12.22

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



REFER TO DETAIL 'C'
FOR HOLE DETAILS

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)



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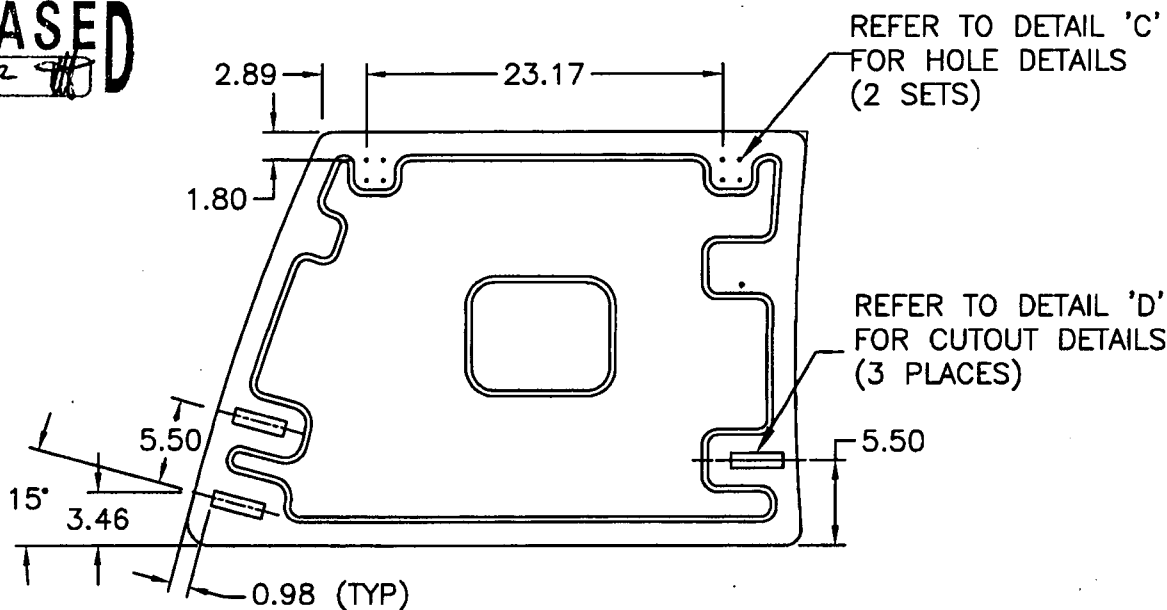
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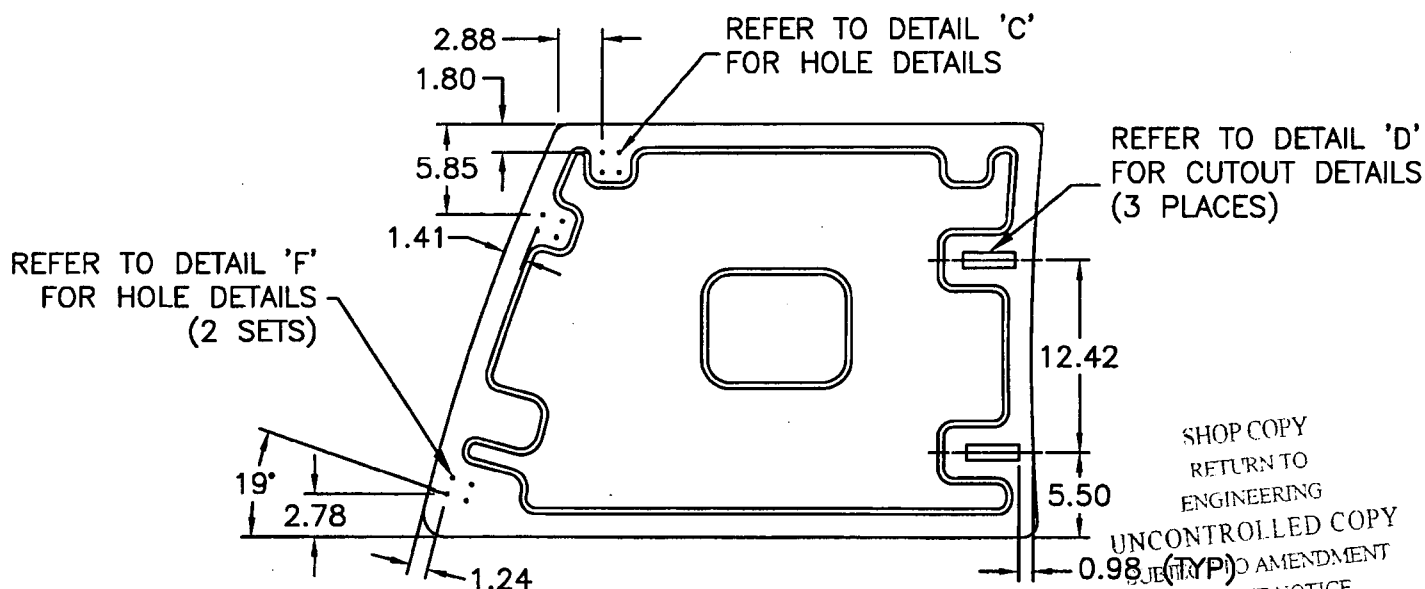


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
06.12.22



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

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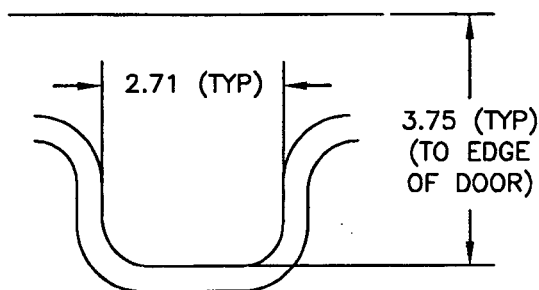
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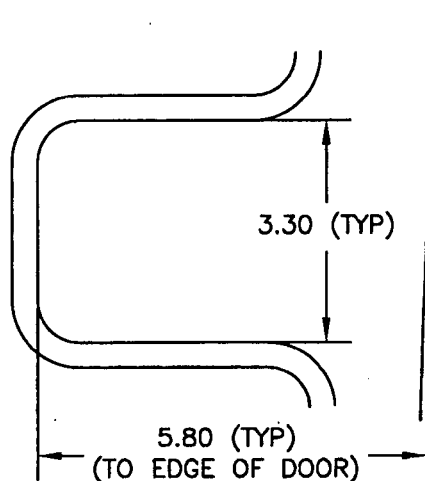
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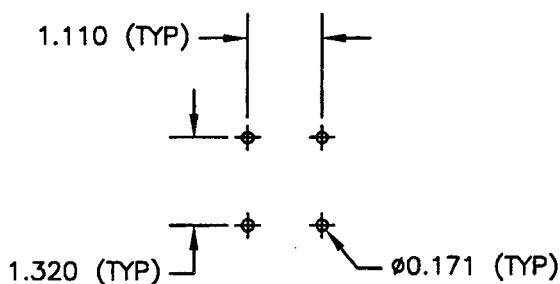
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



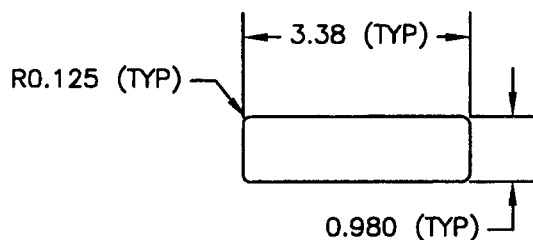
DETAIL A



DETAIL B

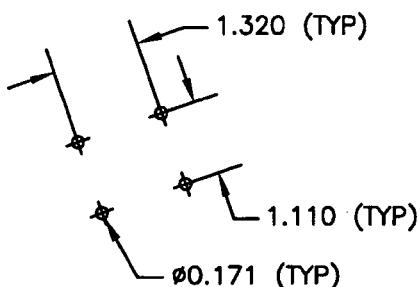


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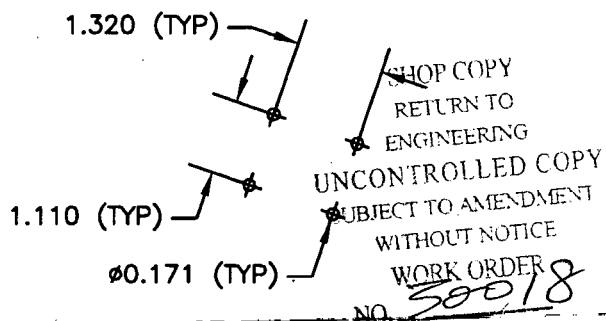


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

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06.12.22

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Date: Wednesday, 12/20/2006 1:45:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY LH
Job Number	: 30028		
Estimate Number	: 12595		
P.O. Number	:	Part Number	: D31881M
This Issue	: 12/20/2006 S.O. No. :	Drawing Number	: D3188 REV <i>PC</i> <i>UE</i> 07-01.18
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : PURCHASED PARTS	Drawing Revision	: <i>PC</i> 07-01.18
Previous Run	: 30027	Material	:
Written By	:	Due Date	: 2/5/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>061220</i>		
Comment	: Est Rev:A New issue ecn882 06-11-30 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8 D2213 Spacer Batch: *B25325* *C207/01/02 (8)*

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *2767*

Description: D3188-1 BODY

Ship: D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

C206/12/21 (1)

3.0	D31881P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

C27/3/5 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:45:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 30028

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

ml 07/03/16

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/03/16

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
D 07/04/05

Job Completion



il 07/04/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
JB		LE		HAMKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. C
DATE		TITLE		SHEET 1 OF 11	
06.12.13		SPACEPOD BODY		SCALE	
A		03.04.03		NEW ISSUE	
B		06.10.06		UPDATED DWG TO MATCH PRODUCT	
C		06.12.13		ADDED D3188-1M/-2M/-3M/-5/-6/-7	
				REMOVED D0600-XXX LABELS	

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

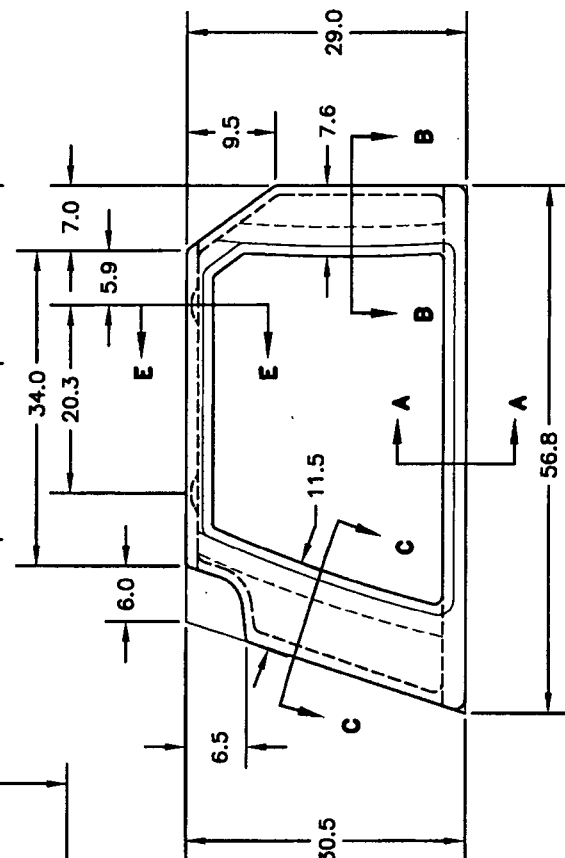
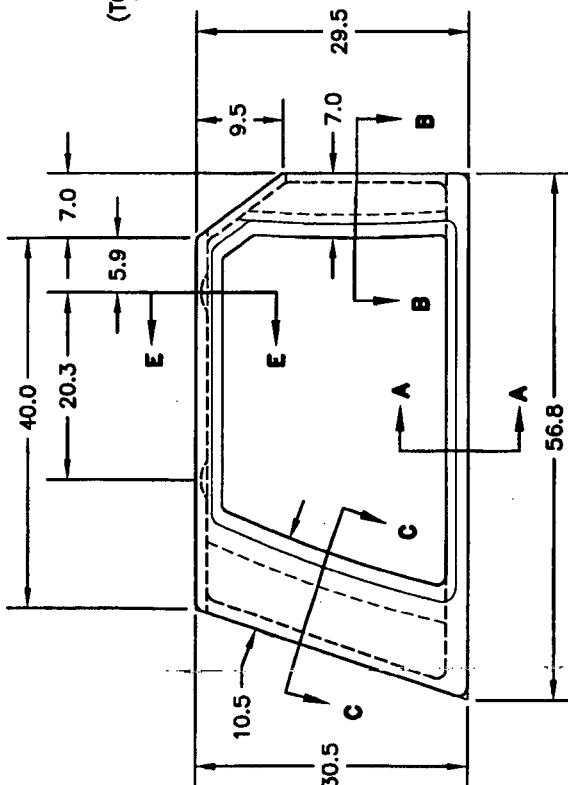
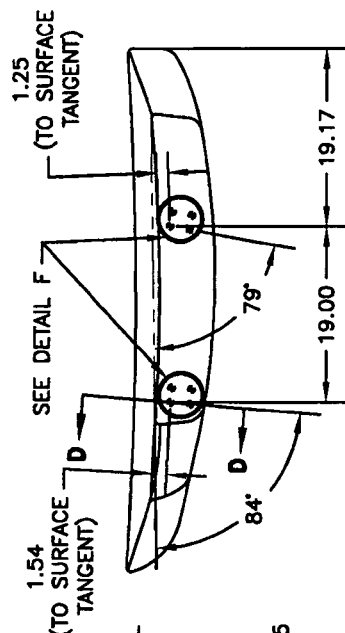
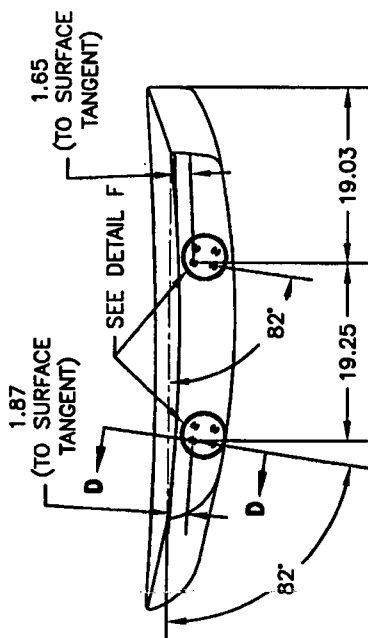
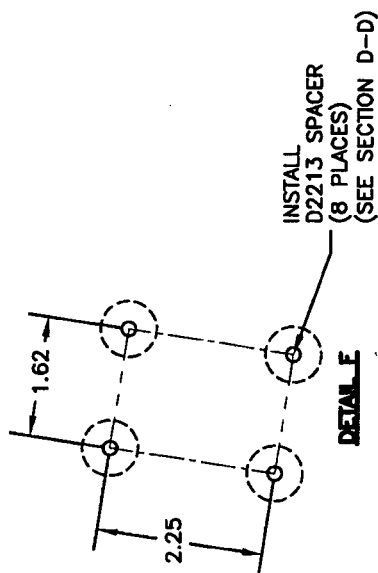
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-3M SPACEPOD BODY

D3188-1M SPACEPOD BODY

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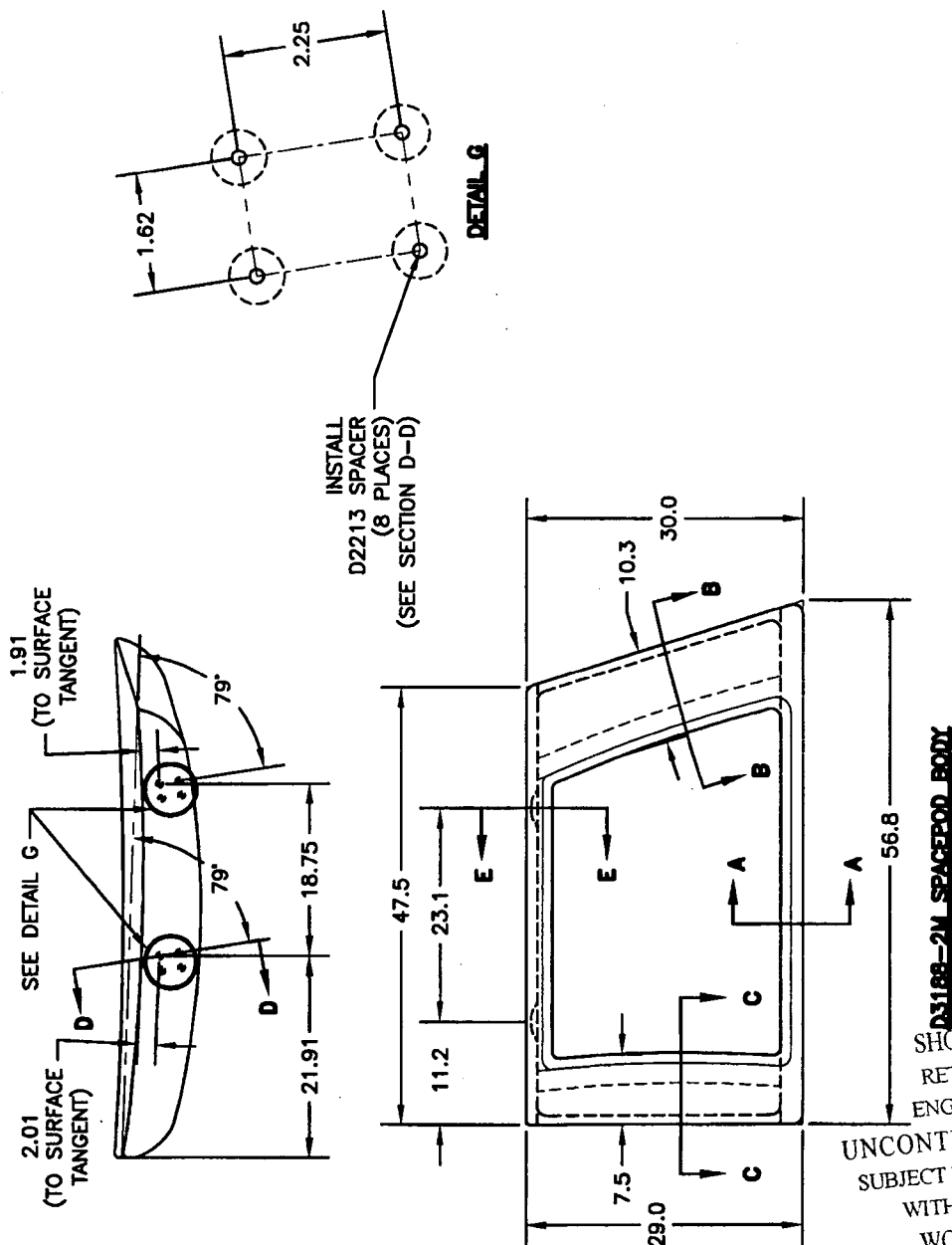
SEE SHEET #4 FOR SECTION VIEWS

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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



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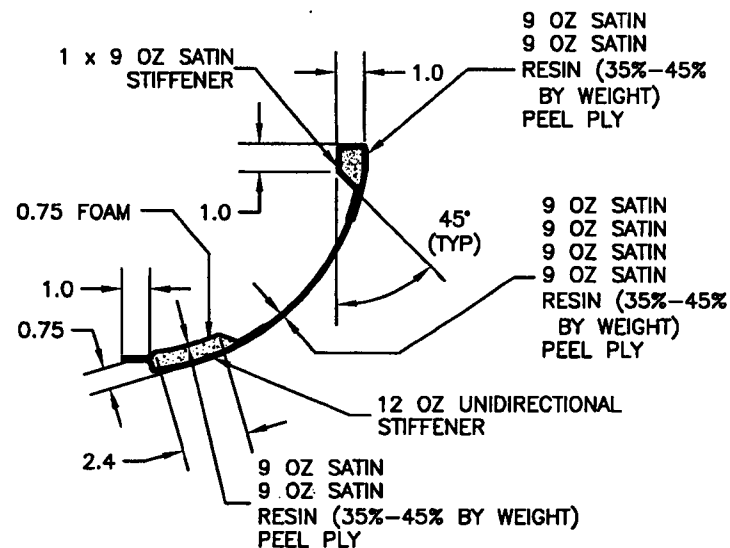
NOTE:
SEE SHEET #4 FOR SECTION VIEWS

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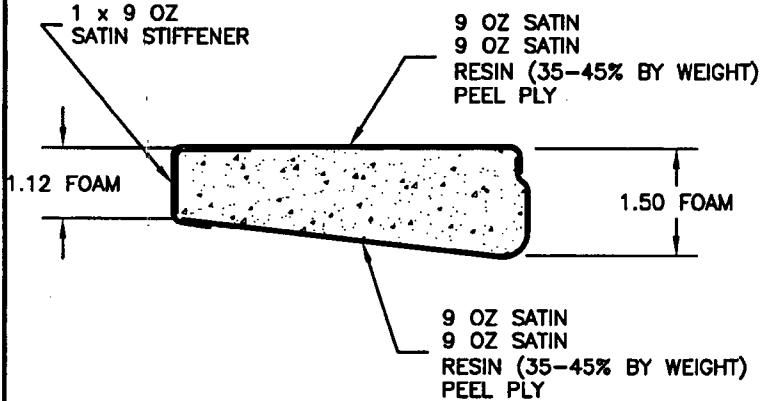
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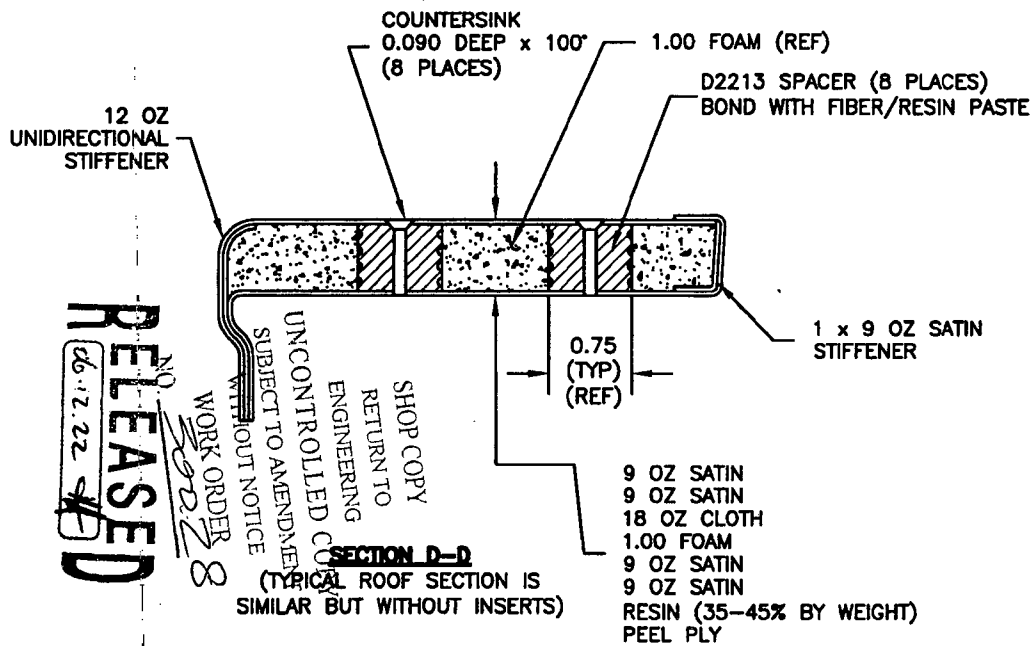
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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.12.13	DRAWING NO.	D3188	REV. C
TITLE	SPACEPOD BODY	SCALE	SHEET 4 OF 11	



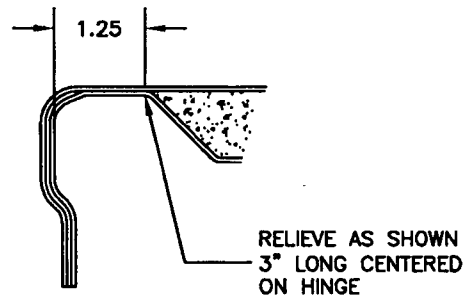
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

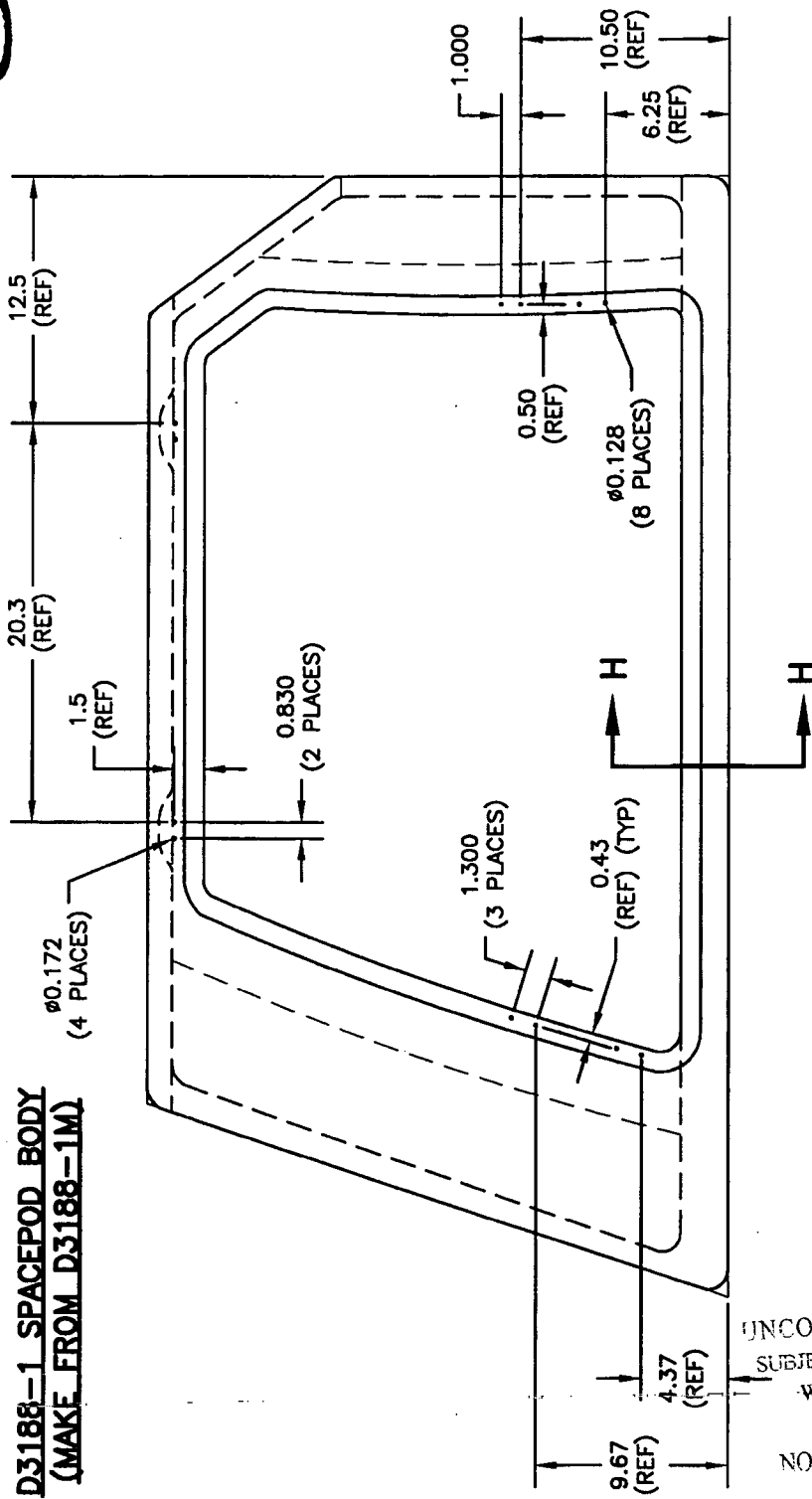
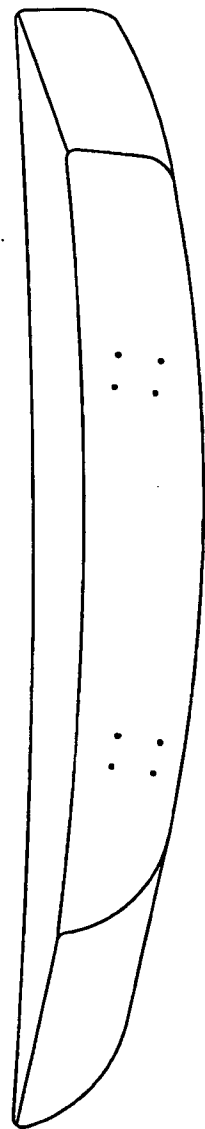
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW
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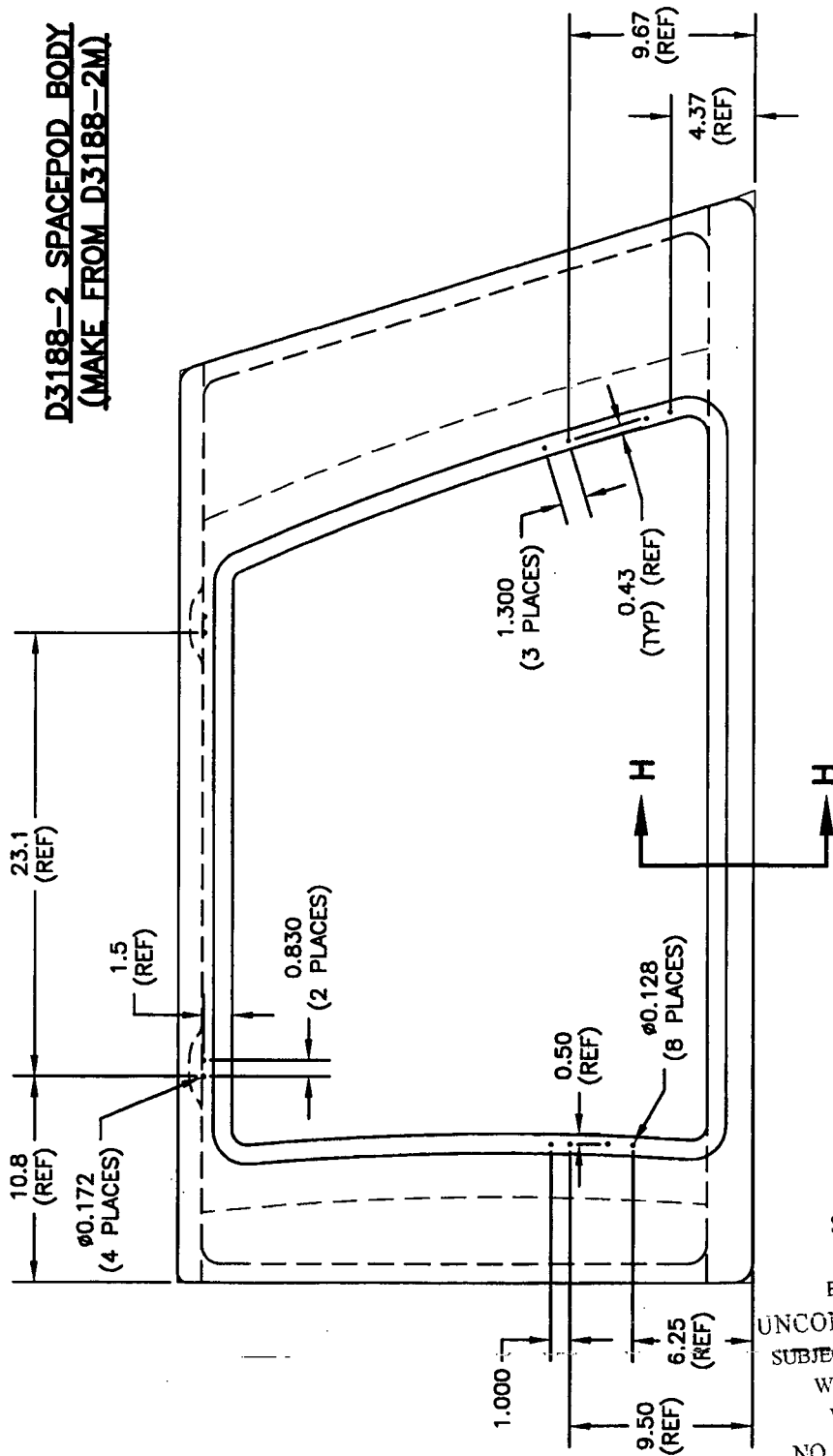
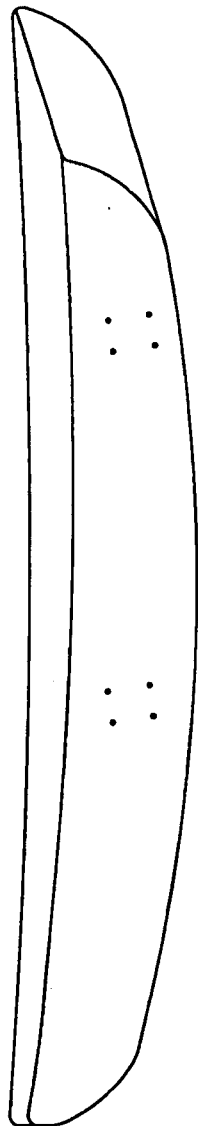
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
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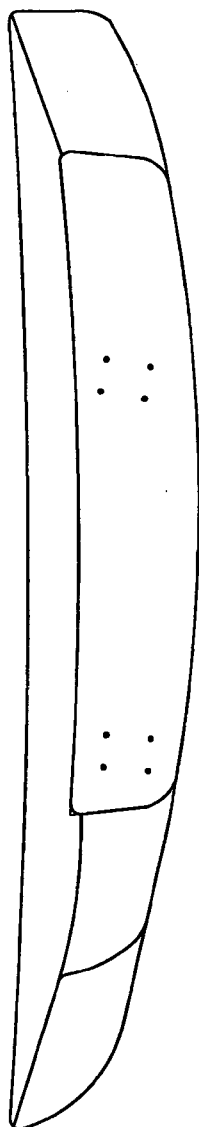
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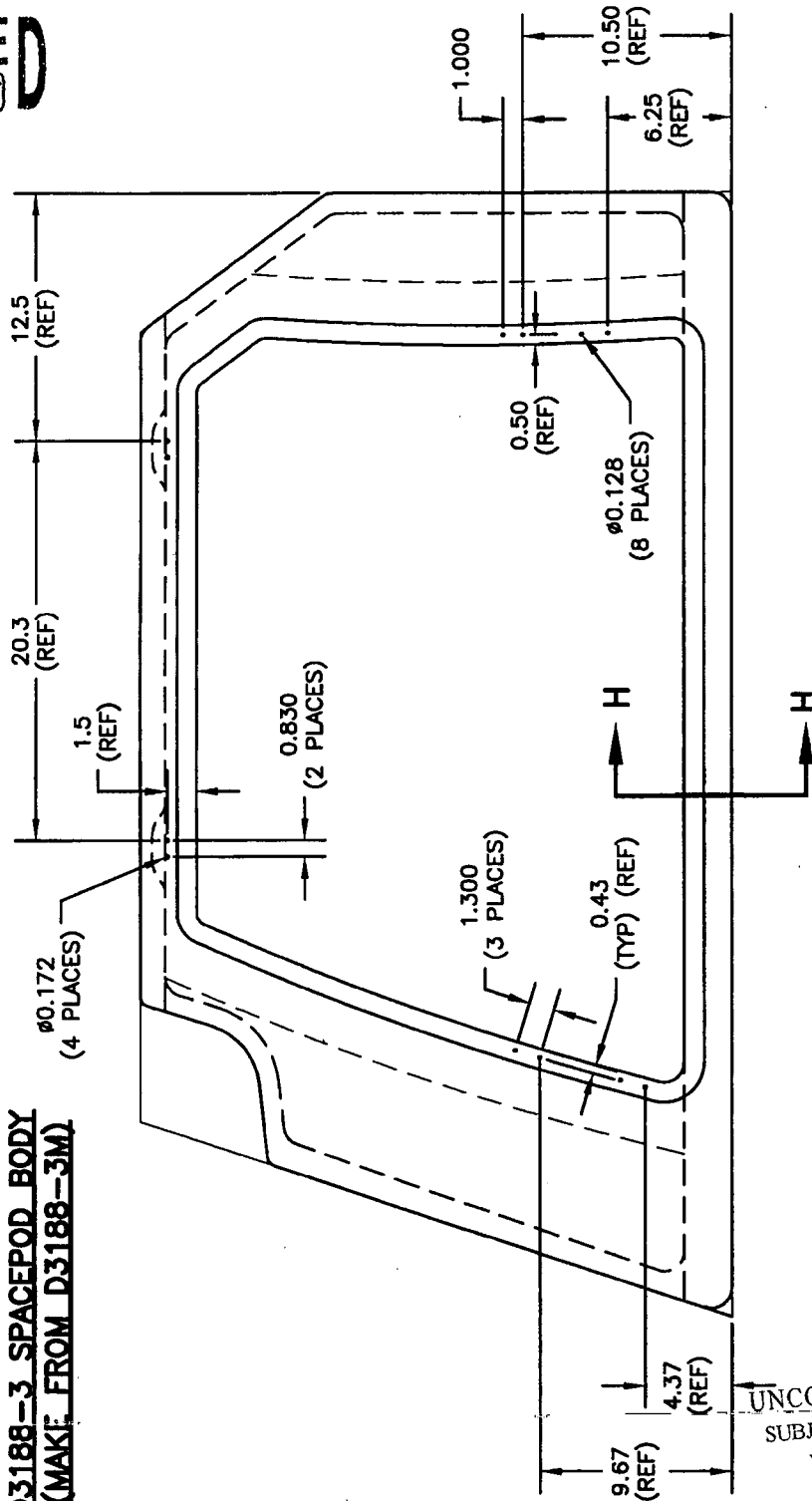


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22



**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEW

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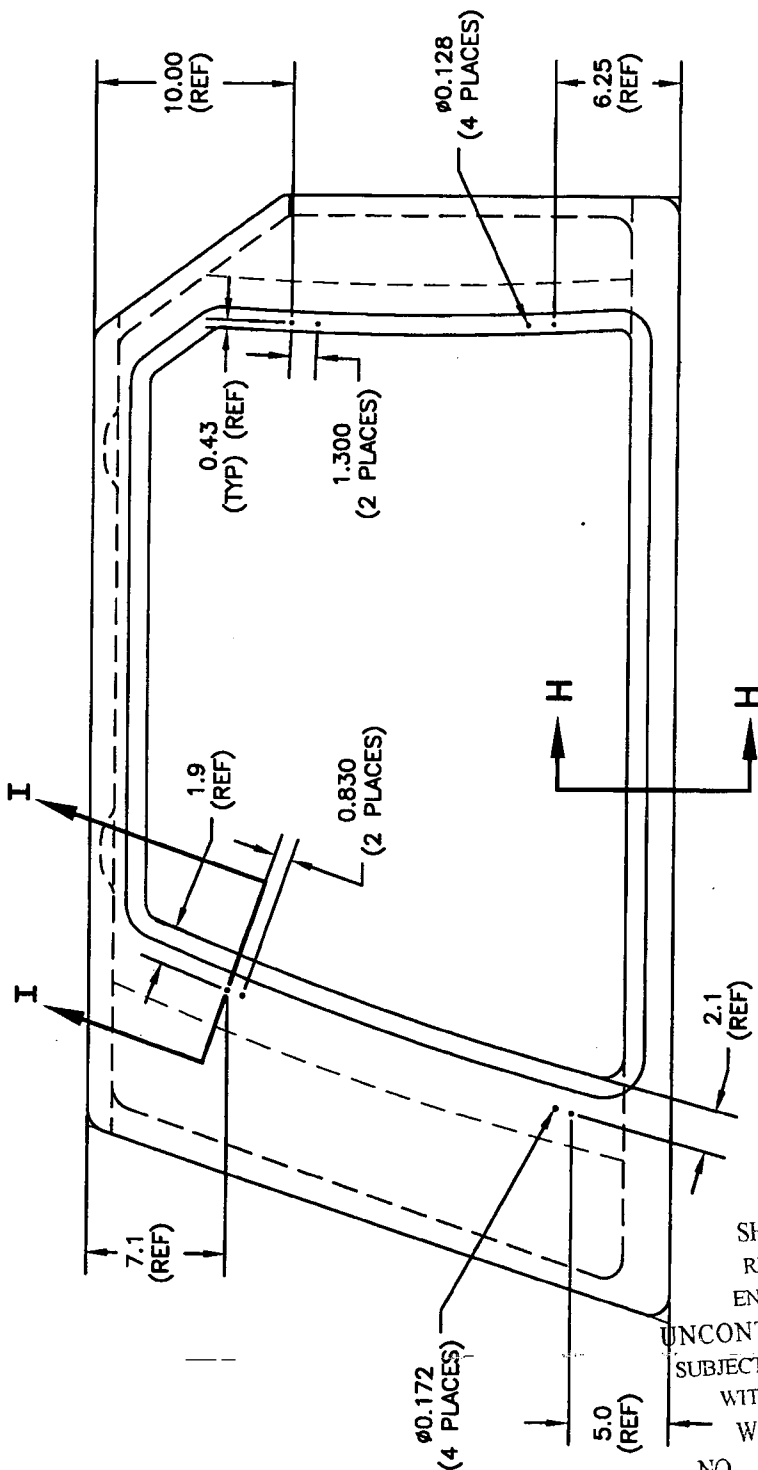
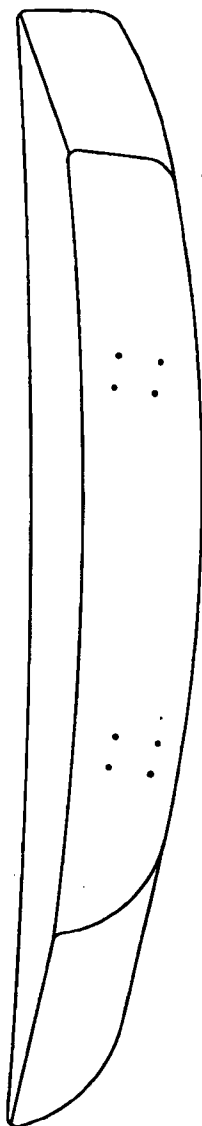
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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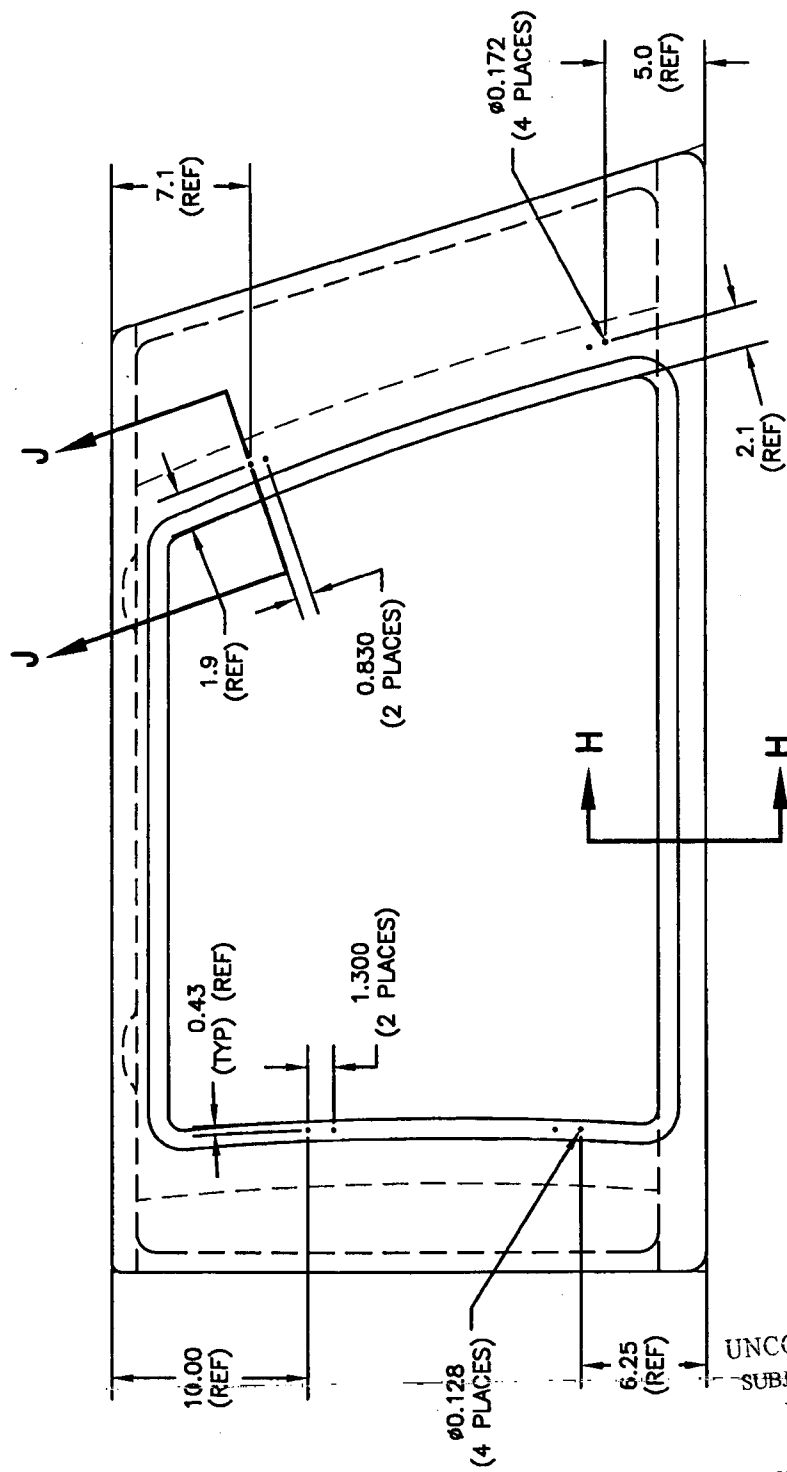
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22 [Signature]

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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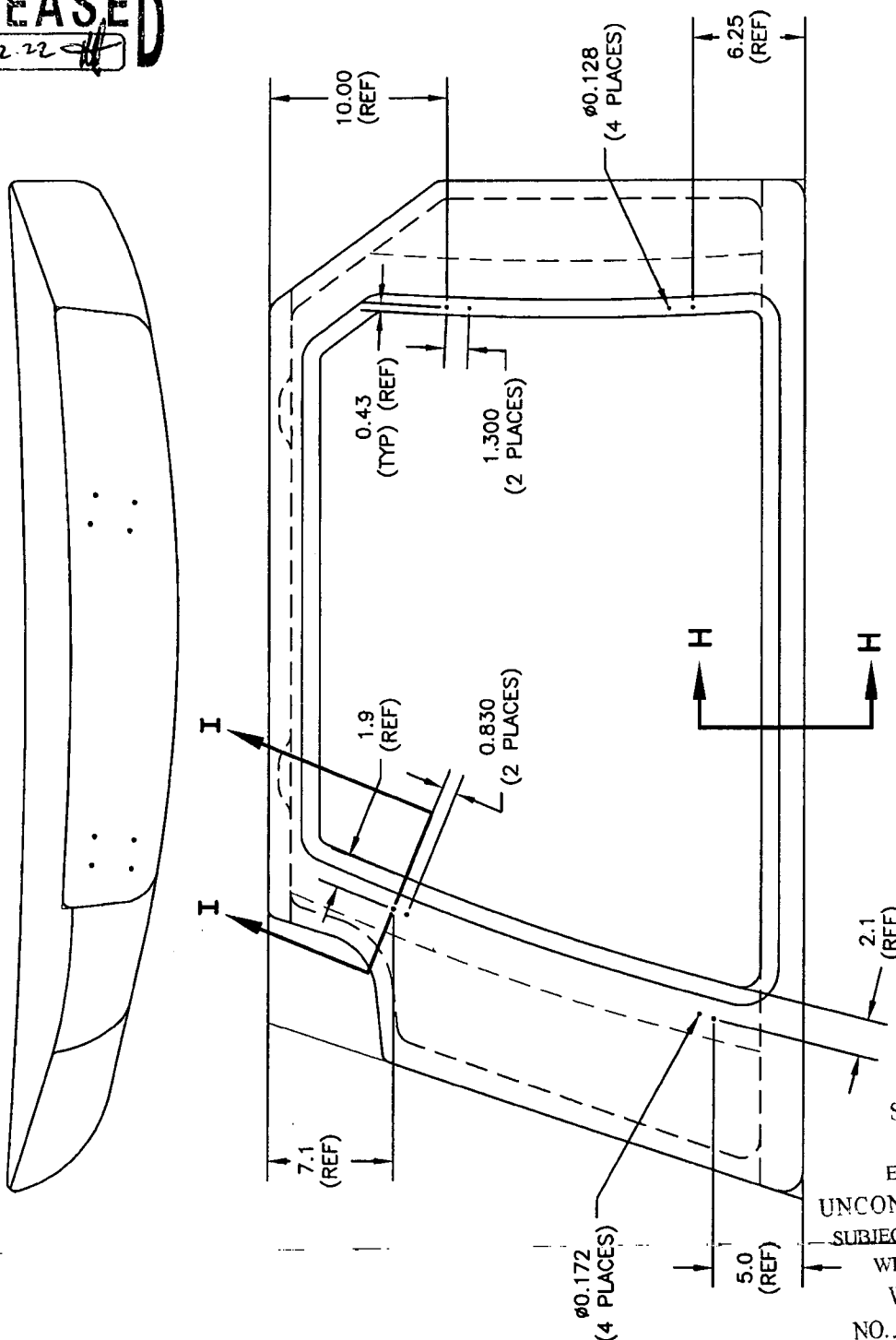
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

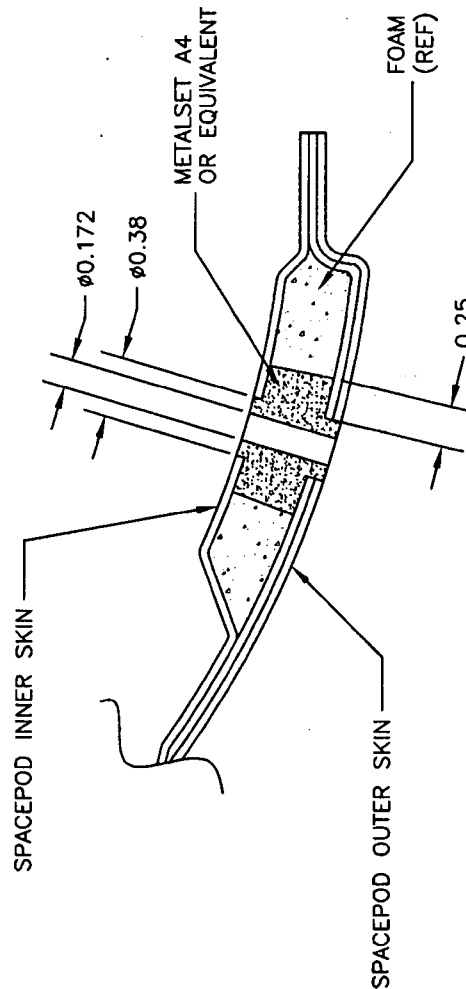
RELEASED
06.12.22

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)

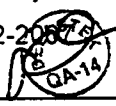


SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Description du produit: Spacepod door			Vendor code:	
Client: Dart Aerospace	P/N: D3188-1M	Rev.: F/D : C	EO: n/a	
		Rev. P/L : n/a		
No commande:		Livraison:	Physical change:	
		FAI <input type="checkbox"/>	FI <input checked="" type="checkbox"/>	
Formulaire d'inspection: INDK-134-0052		Par: Paul Aubry		
Numéro de travail: 41038		Date : 27-02-2007 estampe 		
Quantité à produire : 1		Qtée finale acceptée:		

Matériel							
Spécification	S	A	R	Méthode d'inspection	Notes		
Resin Derakane 411B1620 / 411B7530				C. of C. # <u>1-5988-1</u>			
Fibre 9 oz no.7781 satin, 12 oz unidirectional fiberglass				C. of C. # Refer to planning			
Foam A500 core cell				C. of C. # <u>3-5915-3</u>			
Grey highbuilt dupont primer 1144-s				C. of C. # <u>1-5931-2</u>			
Dimensionnelle							
Référence à dessin	Dimension et tolérance (pouce)	Dimension inspectée	S	A	R	Méthode d'inspection	Notes
	7.2 ± 0.1	6.72			✓	caliper	
	20.2 ± 0.1	20.2		✓		tape	
	4.1 ± 0.1	4.25			✓	caliper	
	6.4 ± 0.1	6.4		✓		caliper	
	5.5 ± 0.1	5.52		✓		caliper	
	3.4 ± 0.1	3.3		✓		tape	
	15 deg ± 0.5	15°		✓		angle	
	1.30 (typ) ± 0.03	0.91 @ 1.1			✓	caliper	

	12 oz unidirectionnal 4.5 ± 0.1 wide along outside edge	5.0			✓	caliper	
	5.5 ± 0.1	5.65			✓	caliper	
	12.4 ± 0.1	12.25			✓	tape	
Detail A	2.71 (typ) ± 0.03	2.5 @ 2.71			✓	caliper	
	3.75 (typ) ± 0.03	3.7 @ 3.8			✓	caliper	
Detail B	3.30 ± 0.03	3.1 @ 3.2			✓	caliper	
	5.8 ± 0.03	5.25 @ 5.35			✓	caliper	

Inspection visuelle

Référence à	Opération	S	A	R	Méthode d'inspection	Notes
	Aspect visuel de la pièce, la surface apparente devrait contenir aucun défaut		✓		Visual	
	Tap test (délamination)		✓			

Acceptation final par:



Date

27-02-2007.

☐ Refusé☒ Qtée accepté: 1

R.M.N.C. No.:

Commentaires:

Rapport d'inspection pour mise à jour du dessin par le client.

Vérifié & Approuvé par

Commentaires

N° de pièce Dart Aerospace : D31861M
N° de Projet Delastek: DK-362

Process Sheet Rev.: 00 Création du premier à partir du
DKC134-0017

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s) Frekote 44NC		
--	--	--

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE		
--	--	--

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 9/02/07 Heure Début: _____ Heure Fin: _____ Sceau:

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s) Tissu à délaminer Release ply B		
---	--	--

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s) Wrightlon 5200 Bleu P3		
--	--	--

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) Feutre de drainage N° Airweave N 10		
---	--	--

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) Stretchlon 200 poche à vide Vert		
--	--	--

Date: Mercredi, 2007-02-21 13:42:10

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41038

Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Commentaire Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s) 9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: <u>1-5905-1</u>		
8.0	AAC0098	Ruban à gommer jaune #: T/AT-200Y
Commentaire Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s) Ruban à gommer jaune #: T/AT-200Y		
9.0	AAC0443	Fiberglass 12 oz Unidirectional
Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s) Fiberglass 12 oz Unidirectional N° de Lot: <u>5955</u>		
10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 9/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____

11.0	AAC0275	Catalyst N° DDM-9
Commentaire Qty.: 0.0080 PINTE(s)/Unit Total : 0.0080 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>5921</u>		
12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
Commentaire Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5908-1</u>		
13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 12/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____

Date: Mercredi, 2007-02-21 13:42:10
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41038

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

14.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8005 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 12/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



15.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 12/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



Curing Début: _____ Curing Fin: _____

16.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921














17.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5988-1

Date: Mercredi, 2007-02-21 13:42:10
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 41038		Numéro Article: DKC134-0052	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART	
			
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL			
Faire la préparation de la résine selon les quantités requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.			
Laisse sécher pendant 2 heures.			
Date: <u>21/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
19.0	DKC134-0056	Foam Core N° D3186-101 (Porte D3186-1)	
Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D3186-101 (Porte D3186-1) No LOT: <u>3-5915-3</u>			
20.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s) Polybond B46F N° de Lot: <u>1-5865-1</u>			
21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs ASSEMBLAGE GÉNÉRALE DES PIÈCES			
Retirez le bagging.			
Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.			
Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.) <u>FIRST OFF 21-2-07</u> 			
Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0024 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.			
Date: <u>21/02/07</u> Heure Début: _____ Heure Fin: _____ Sceau:   			
22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs EFFECTUER LA POCHE A VIDE			
Faire la poche à vide en appliquant les composantes dans l'ordre suivant:			
1- Tissu à délaminer			
2- Feutre de drainage			

Date: Mercredi, 2007-02-21 13:42:10
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41038

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond.

Date: 21/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



Curing Début: _____ Curing Fin: _____

23.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

24.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5988-1

25.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



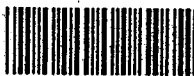
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 22/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



26.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte .

Faire le laminage du dernier pli de 9.7 oz.

Date: 22/02/07 Heure Début: _____ Heure Fin: _____ Sceau: _____



Date: Mercredi, 2007-02-21 13:42:10
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41038

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 22/02/07

Heure Début:

Heure Fin:

Sceau:



Curing Début:

Curing Fin:

28.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIECES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini lisse de celui-ci

Date: 23/02/07

Heure Début:

Heure Fin:

Sceau:



29.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer la pièce à l'aide du gabarit de trimage prévu à cet effet.

Percer les trous de Hatch et de pentures selon le dessin N° D3186

Date: 23/02/07

Heure Début:

Heure Fin:

Sceau:



Date: mercredi, 2007-02-21 13:42:10
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41038

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

30.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S

No lot 1-5931-2

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S

No lot 1-5931-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S

No lot 1-5692-2

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

23-02-07



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer la première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. #
Application du primer.

Laisser sécher pendant 3 heures.

23-02-07



Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

35.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfections et enlever le lustre du
primer.

Date: Mercredi, 2007-02-21 13:42:10
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41038

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

36.0 AAC0446 Label N° D0600-145

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Label N° D0600-145 N° de Lot: *à enlever*

37.0 AAC0444 Surface Veil

Commentair Qty.: 0.08 VERGE(s)/Unit Total: 0.08 VERGE(s)

Surface Veil N° de Lot:

38.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total: 0.015 GALLON(s)

Résine Mia-Poxy N° de Lot: *N/A*

39.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTÉ(s)/Unit Total: 0.030 PINTÉ(s)

Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: *N/A*

40.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Hrs Total Run: 15.0000Hrs

FABRICATION GÉNÉRALE DART

Coller le Label N° 0600-145 selon les séquences suivantes:

1 Surface Veil

2- Label

3- Surface Veil

à enlever.

A l'aide de la résine Mia-Poxy selon le dessin D3186.

Laisser sécher pendant 6 heures.

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

41.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

42.0 AAC0646 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.050 KIT(s)/Unit Total: 0.050 KIT(s)

MASTIC POLYSTOP SIKKENS 3AR591

No Lot 1-6005-1

43.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total: 0.039 UNITE(s)

Durcisseur Polysoft #004009 Sikkens N° de Lot: *1-6005-1*

44.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

FINITION GÉNÉRALE

Date: Mercredi, 2007-02-21 13:42:10
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41038

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 26-2-07 Heure Début: 09:00 Heure Fin: 12:00 Sceau:

45.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-5931-2

46.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-5931-1

47.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-6082-2

48.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
PRÉPARATION DU MATÉRIEL

FEB 26 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

49.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs
APPLICATION DE PRIMER

Masquer le label

Appliquer la deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. #

Application du primer

Date: FEB 26 2007 Heure Début: 14:00 Heure Fin: 16:00 Sceau:

50.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
INSPECTION PIÈCE DART

Voir Rapport d'inspection dans la
feuille du client

Emballage QT 1 27/2/07





DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11642
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson		
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233		
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #		
27/02/07	21/12/06	5092	C. Lavoie		PO00002767			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description				
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30018 Dwg. Rév.: C Job: 41038				U de M : Each
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30038 Dwg. Rév.: C Job: 41039				U de M : Each

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:



27-2-07

Quality department

AQ-357

as per inspection report



DELASTEK COMPOSITES INC.
2699, Sième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLI CERTIFICATE OF COMPLIANCE

Invoice #	11645
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
28/02/07	21/12/06	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30028 Dwg. Rév.: C Job: 40968 U de M : F			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30048 Dwg. Rév.: C Job: 40970 U de M : F			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

28/2/07

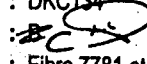
Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Vendredi, 2007-02-09 09:14:44
 Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART	Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD BODY	
Numéro Job :	40968		Numéro Article :	DKC134-0053	
Numéro Soumission :	2585		Numéro Dessin :	D3188	
Numéro B.A. :			Projet Numéro :	DKC134	L/H
Cette fois :	2007-02-09	No. B.V. :	Révision dessin :		
Prsht Rev. :	NC		Matériel :	Fibre 7781 et Résine 411-350	
Prem. fois :	--	Type :	Date Dûe :	2007-02-16	Qté: 1 Udm: UNITE
Job précédente :	40967				



Écrit par : 
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Dart Aerospace : D31881M
 N° de Projet Delastek: DK-362

 Process Sheet Rev.: 00 Création du premier à partir du
 DKC134-0019

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
 		
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006. Date: <u>15-01-07</u> Heure Début: _____ Heure Fin: _____ Sceau: <u>DK</u>		
3.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s) Feutre de drainage N° Airweave N.10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s) Stretchlon 200 poche à vide Vert		

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s) 9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: <u>1-5905-1</u>		

8.0 AAC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)
Fiberglass 12 oz Unidirectional N° de Lot: 1-5455-1

10.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentair Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)
WR1850 ROVING 18 OZ x 50" N° de Lot: 1-5873-1

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 15-4-07 Heure Début: _____ Heure Fin: _____ Sceau: KG

12.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 5921

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-5866-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)
Fibre de verre Miapoxy 66N° de Lot: 1-5502-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Vendredi, 2007-02-09 09:14:44

Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 40968

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxly 66.

Date: 16-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SU

16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 16-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SU CG

17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage.
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

Date: 16-01-07 Heure Début: _____ Heure fin: _____ Sceau: DR SU CG

Curing Début: _____ Curing Fin: _____

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit. Total: 0.75 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 1-5836-1

Date: Vendredi, 2007-02-09 09:14:44
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

19.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler et le Foam Core 1" selon plan de découpe et gabarits

Date: 17-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

20.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5957-2

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

22.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le
Foam Core. 17-01-07 DR

23.0 AAC0452 Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)
Polybond B46F

N° de Lot: 1-5865-1

24.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

A l'aide de polybond, coller ensemble les deux surfaces scellées

Disposer des poids sur les pièces pour conserver une pression de collage.

Laisser sécher 2 heures minimum.

Quantité: 1 Date: 17-01-07 Sceau: DR

Date: Vendredi, 2007-02-09 09:14:45

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40968

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: _____ Date: _____ Sceau: _____

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

TRIMAGE COMPOSITES DART

Ajuster chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: 18-01-07 Sceau: DR

Quantité: _____ Date: _____ Sceau: _____

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot.: 1-59572

27.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)

Catalyst N° DDM-9

N° de Lot.: 5921

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promu 75 minutes.. 18-01-07 DR

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

FABRICATION GÉNÉRALE DART

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G. # Sceller le Foam Core

Laisser sécher pendant 2 heures minimum.

Date: 18-01-07 Sceau: _____ Initiales: DR

Date: Vendredi, 2007-02-09 09:14:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

30.0 AAC0452 Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s)
Polybond B46F N° de Lot: 1-5865-1

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du Polybond.

Date: 19-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR CG SV

32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

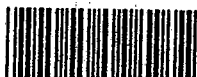


Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: 19-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR CG SV

33.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé

Date: 19-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR CG SV

Curing Début: _____ Curing Fin: _____

Date: Vendredi, 2007-02-09 09:14:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikks

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikks

N° de Lot: 1-5957-1

35.0 AC0059 Durcisseur Polysoft #004009 Sikks

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikks

36.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikks. Pour les plos gros défauts, utiliser du polybond.

Date: 19-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

19-01-07 DR
Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5957-2

39.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

40.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le fom Core

Laisser sécher pendant 2 heures minimum.

19-01-07 DR

Date: . Vendredi, 2007-02-09 09:14:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968

Norm Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: _____ Date: _____ Sceau: _____

Quantité: 1 Date: 19-01-07 Sceau: DR

41.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

42.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5966-1

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.

Date: 22-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

44.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 S-Glass partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: 22-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SU CG

45.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage

Date: Vendredi, 2007-02-09 09:14:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 22-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR CF SL

Curing Début: _____ Curing Fin: _____

46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIECES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 23-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801.

Par l'intérieur, percer les 8 dégagement de $\varnothing .745"$ pour les spacers. (Ne pas percer la peau extérieur de la pièce)

Date: 23-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR

48.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5957-2

Date: Vendredi, 2007-02-09 09:14:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

50.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total: 0.0420 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

51.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.

Date: 23-07-07 Heure Début: _____ Heure Fin: _____ Sceau: SV

52.0 AAC0448 Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total: 8 UNITE(s)
Spacer N° D2213 N° de Lot: 1-5848-1

53.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N°
411-350 chargé à l'aide de Fibre de verre Miapoxy 66

Laminer une pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous.

Appliquer une pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autobloquantes.

Laisser sécher pendant 4 heures minimum.

Date: 23-01-07 Heure Début: _____ Heure Fin: _____ Sceau: SV

Curing Début: _____ Curing Fin: _____

54.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

Date: . Vendredi, 2007-02-09 09:14:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

55.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot.: 1-5957-2

56.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

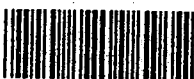


Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 24-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SC

57.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et les blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 S-Glass sur le contour de la pièce selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: 24-01-07 Heure Début: _____ Heure Fin: _____ Sceau: DR SC

Curing Début: _____ Curing Fin: _____

58.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.

Percer les 8 trous des spacers afin de les déboucher.

Quantité: 1 Date: 25-01-07 Sceau: DR

Quantité: 1 Date: 26-01-07 Sceau: MA

Date: Vendredi, 2007-02-09 09:14:45

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 40968

Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

59.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)
Dupont Primer N° 1104S

60.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activator N° 7975S

61.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)
Dupont Reducer N° 12375S

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

29-01-07 YL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

63.0 PEINT/PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer le primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. Application de primer.

Laisser sécher 3 heures minimum.

Date: 29-01-07 Heure Début: _____ Heure Fin: _____ Sceau: YL

64.0 AAC0445 Label N° D0600-141

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Label N° D0600-141 N° de Lot: _____

65.0 AAC0501 Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total : 0.015 GALLON(s)
Résine Mia-Poxy N° de Lot: _____

66.0 AAC0502 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTE(s)/Unit Total : 0.030 PINTE(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: _____

67.0 AAC0444 Surface Veil

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)
Surface Veil N° de Lot: _____

Date: Vendredi, 2007-02-09 09:14:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

68.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DART

Coller le label D0600-141 sur le spacepod en plaçant un suface veil eu dessous et par dessus le label à l'aide de résine Mia Poxi selon I.F. # DKC134-0019-13

Date: _____ Heure début: _____ Heure fin: _____ Sceau: _____

69.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-5927-1

70.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

71.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikkens

Faire un léger sablage (grit 220) de toutes les surfaces.

Date: 30-01-07 Heure Début: _____ Heure Fin: _____ Sceau: MA

72.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-581-2

73.0 AAC0670 Dupont Activation N° 7975S

Commentaire Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)
Dupont Activation N° 7975S N° de Lot: 1-5931-1

74.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5931-3

75.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Masquer le label.

Date: Vendredi, 2007-02-09 09:14:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40968

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

3-01-07 YL

76.0

PEINT/PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un minimum de 3 heures.

Date: 3-01-07 Heure Début: _____ Heure Fin: _____ Sceau: YL

77.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 7-02-07 Sceau:  Initiales: 

EMBALLAGE 7-02-07

